

SEWING MACHINE HEAD

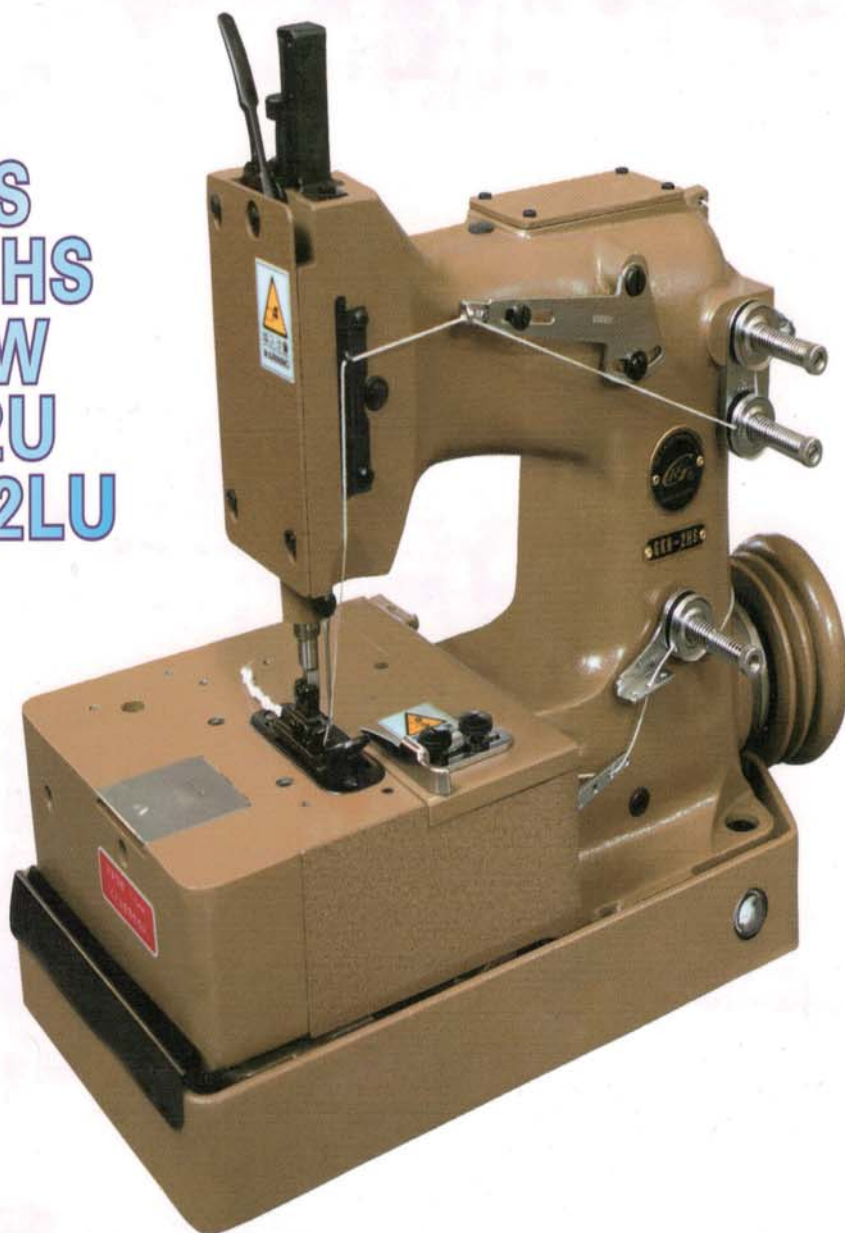
GKN-2

制袋用缝纫机

INSTRUCTION MANUAL
说明书指南
PARTS LIST/零件表

MODEL

GKN-2HS
GKN-2LHS
GKN-2W
GKN-2U
GKN-2LU



For Operator Safety

安全对策

Thank you for purchasing the Model GKN-2 HS Bag Sewing Machine Head.

感谢你购买型号 GKN-2 HS 封口袋缝纫机

- This manual contains the instructions and precautions for using the Model DN-5U Bag Sewing Machine Head. Be sure to read and understand this manual before use and use the machine correctly.
- Keep this manual near the sewing machine for easy reference. Be sure to attach this manual to the machine when lending or transferring it to another person or company.
- Please order this manual from the nearest office if it is lost.
- The contents of this manual are subject to change without prior notice for improvement and safety purpose.

- 该使用说明书内容包括缝纫机的操作方法和使用时的注意事项。在开始正确使用机器前,请务必阅读理解本说明书。
- 请将本说明书放在缝纫机附近以便查阅。当把该缝纫机借给或转给其他人或公司时,请务必把这本手册附到缝纫机上。
- 如果该说明书丢失,请联系最近的办事处,请求另送一本说明书。
- 为了改进和安全,本说明书的内容可能随时变更,恕不提前通知。



Hazard of Being Caught in the Machine

- Be careful, when you insert a bag to be closed into the sewing machine, or your fingers may be caught in the machine between the presser foot and feed dog.
- A "Hazardous" mark is attached to the machine. When sewing, be sure not to touch on the machine.



卷入机器的危险

- 当用手把口袋插入缝纫机中缝口时,要当心,否则手指可能会被卷入压脚和推布牙之间的机器中。
- 缝纫机上要贴上“危险”标记。当进行缝纫时,务必不得接触到机器。



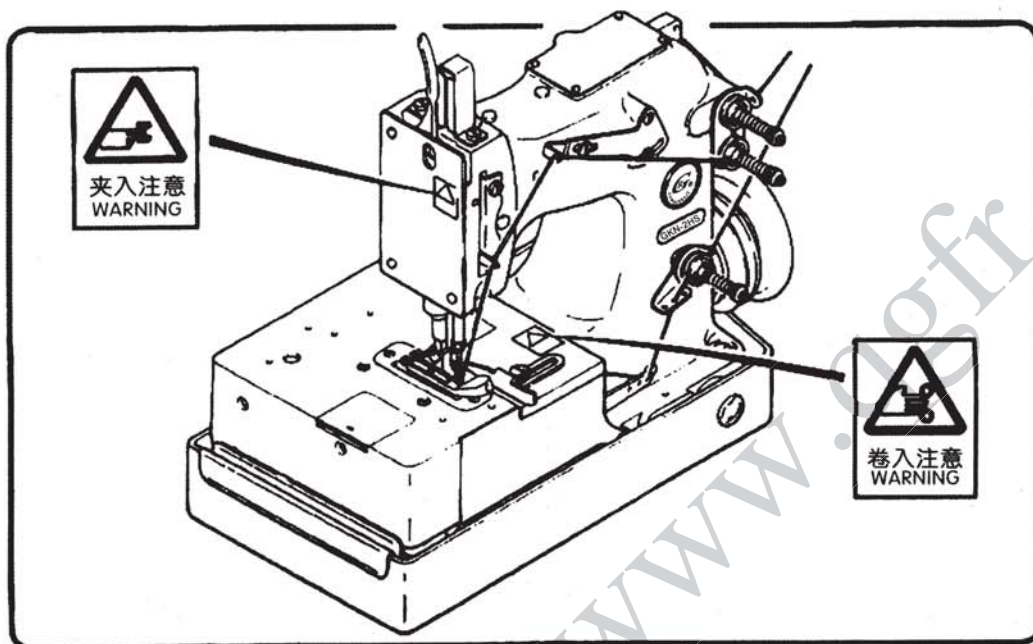
Hazard of Being Caught in the Machine

- A Needle Bar and Needle Thread Take-UP are moving at high speed. A "Hazardous" mark is attached to the machine. When the machine is operation, keep fingers and yourself away from the Needle Bar and Needle Thread Take-UP



卷入机器的危险

- 针杆和针挑线高速移动。机器上要贴上“危险”标记。当机器在运行时,你本人和手指要远离针杆和针挑线。



- The instruction manual and parts list is subject to change without prior notice.
- 说明书和零件清单可能随时变更,恕不提前通知。

WARNING

PERSONAL INJURY MAY RESULT IF THE FOLLOWING SAFETY PRECAUTIONS ARE NOT OBSERVED.

1. BE SURE THE AREA SURROUNDING MACHINE IS FREE OF ALL HAZARDS SUCH AS FIRE, WATER, OIL, RUBBISH OR ANYTHING THAT CAN CAUSE INJURY.
2. DO NOT OPERATE MACHINE IN AN EXPLOSIVE AREA OR UNDER WET CONDITIONS. THE MACHINE IS NOT AN EXPLOSION-PROOF TYPE NOR WATER-PROOF TYPE.
3. DO NOT OPERATE MACHINE BEFORE READING INSTRUCTION MANUAL.
4. DO NOT OPERATE MACHINE ON VOLTAGES OTHER THAN SPECIFIED FOR THE MACHINE.
5. BE SURE MACHINE IS CONNECTED TO BUILDING ELECTRICAL SAFETY GROUND (EARTH).
6. BE SURE POWER (AND AIR SUPPLY) IS OFF BEFORE PERFORMING MACHINE MAINTENANCE, PARTS REPLACEMENT ADJUSTMENTS OR CLEANING.
7. DO NOT OPERATE MACHINE WITH GUARDS AND COVERS REMOVED.
8. DO NOT TOUCH KNIFE, NEEDLE, PULLEY, BELT AND MOVING PARTS WHEN MACHINE IS IN OPERATION.
9. BE SURE MACHINE IS PLACED ON A SMOOTH (LEVEL) SURFACE WHEN PERFORMING MAINTENANCE, PARTS REPLACEMENT, ADJUSTMENTS, CLEANING OR STORAGE.
10. BE SURE THE MATERIAL TO BE SEWN OR CLOSED COMPLIES WITH THE MACHINE SPECIFICATIONS.
11. DO NOT USE SPARE PARTS OTHER THAN "DECHAO" GENUINE PARTS.

警告

如不遵守下列安全预防措施，将有可能造成人身伤害

1. 确定机器周围处无任何危险，如烟火、水、油、垃圾及其他可能引起人身伤害的任何东西。
2. 不得在易爆区或潮湿环境下进行设备操作。该设备不具有防爆和防水性能。
3. 在阅读说明书之前，不得进行设备操作。
4. 不得在该设备规定使用的电压范围之外进行操作。
5. 确保设备与建筑物电气安全接地系统安全连接（接地）。
6. 在进行设备维修、零部件更换、设备调整或清洁前，应确保切断电源（或送气装置）。
7. 在设备防护罩和安全挡板卸下以后，不得运行设备。
8. 当机器运行时，不得接触剪刀、缝针、皮带轮、皮带和其他运转部件。
9. 当在设备维修，零部件更换，设备调整，清洁或设备存放保管时，应将设备放置在光滑（平整）的地方。
10. 用于缝纫或封口的材料必须符合设备技术规格要求。
11. 不得使用除“德超”正品以外的备品备件。

Identifying and Ordering Parts

Where the construction permits, each part is stamped with its part number. On all orders, please include part number, part name and model name of machine.

Safety Rules

To prevent personal injury:

- All power sources to the machine must be turned off before threading, oiling, adjusting or replacing parts.
- All cover and guards must be in position before operating machine.
- Do not tamper with safety cover, guards, etc., while machine is in operation.

Cautions When Using the Machine

Safety Precautions

- 1) Always turn power off before threading, oiling, and adjusting the machine or replacing parts.
- 2) Wear safety glasses.
- 3) Make sure, before starting the machine, that all covers and shields are in place and closed.
- 4) Do not touch on the machine when it is run.
- 5) Turn power off and make sure the cutter does not operate before you put your fingers under the cutter blades and the needles to adjust.
- 6) Do not touch on the machine when it is run.

Maintenance

- Please keep in mind to handle the machine carefully and to maintain the machine in good condition.
- Thread fuzz or dust must be cleaned with air or brush on throat plate, in the groove of feed dog or around looper after the day's work.
- Wipe the area easy to rust with oil cloth.
- Check the machine for loose screws and tighten them, if any, once a month.
- Good maintenance will prolong the machine life.

识别和订购零件

条件允许的情况下, 需要将每个零件刻上零部件号码。在所有订单上, 应包括零部件号码、零部件名称和机器型号名称信息。

安全规则

为了避免人身伤害:

- 在穿缝线、加油、调整机器或更换零件前, 必须关掉缝纫机的全部电源。
- 操作机器前, 所有防护罩和安全挡板必须就位。
- 机器在运行时, 不得胡乱摆弄防护罩和安全挡板等。

使用机器时的注意事项

安全预防措施

- 1) 穿缝线、加油、调整机器或更换零件前, 要关掉电源。
- 2) 需佩戴安全眼镜。
- 3) 启动机器前, 要确信所有防护罩和安全挡板就位并关闭。
- 4) 机器运行时, 不得接触机器。
- 5) 当将手指放在缝针和刀具下进行调整前, 确保关掉电源且刀具不运行。
- 6) 当机器运行时, 不要接触机器。

保 养

- 请牢记小心操作机器, 并且平时要注意维修。
- 每天工作结束后, 必须用空气或刷子清洁针板上、进料齿槽里面或钩针周围的尘土和异物。
- 用油布擦拭容易生锈部位。
- 每月一次检查确认螺钉是否牢固, 如果有松动请进行紧固。
- 良好的保养将会延长缝纫机寿命。

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1. Specifications/技术规格

Model (型号)	GKN-2HS/GKN-2LHS	GKN-2W
Maximum speed (最高转速)	2,800rpm	2,800rpm
Stitch range (缝针范围)	Note) 注 7~12mm	7~11mm
Seam (针距范围)	Double thread chain stitch (type 401) 双线链式缝合(401)	
No. of Needle (针数)	1-needle (1 单针)	2-needle (2 双针)
No. of Thread (线数)	2-thread (2 双线)	4-thread (4 四线)
Needle size (缝针型号)	DR×2-#25 or #26	UY143GS-200 or 230
Lubrication (给油)	automatic (oil-bath system)	自动润滑 (油谷系统)

Note) PP woven cloth bag 7~10.5mm
注)PP编织布袋7-10.5mm

※Parts to Replace for Type of Bag.
※根据袋子用途选用针板、压脚。
根据袋子类别用途按下表选择使用、压脚。

Model (型号)	GKN-2HS		GKN-2LHS	GKN-2W	
Bag Type 袋种类 Parts Name, Parts No, 部件名称 部件号	Paper bag (纸袋用)	Hessian or PP woven cloth bag (麻袋或是聚丙烯无纺布袋)	Paper bag (纸袋用)	PP woven cloth bag (PP/PE编织袋)	Paper & hessian laminated bag (纸和麻复合袋)
Feed Dog (送料齿)	014311	014291	024121	034202	034203
Throat Plate (针板)	014241	014221	024091	034192	034193
Presser Foot (压脚)	012201A	012211A	022081A	032342A	032343A

2. The Points Before Operation/操作前的注意事项

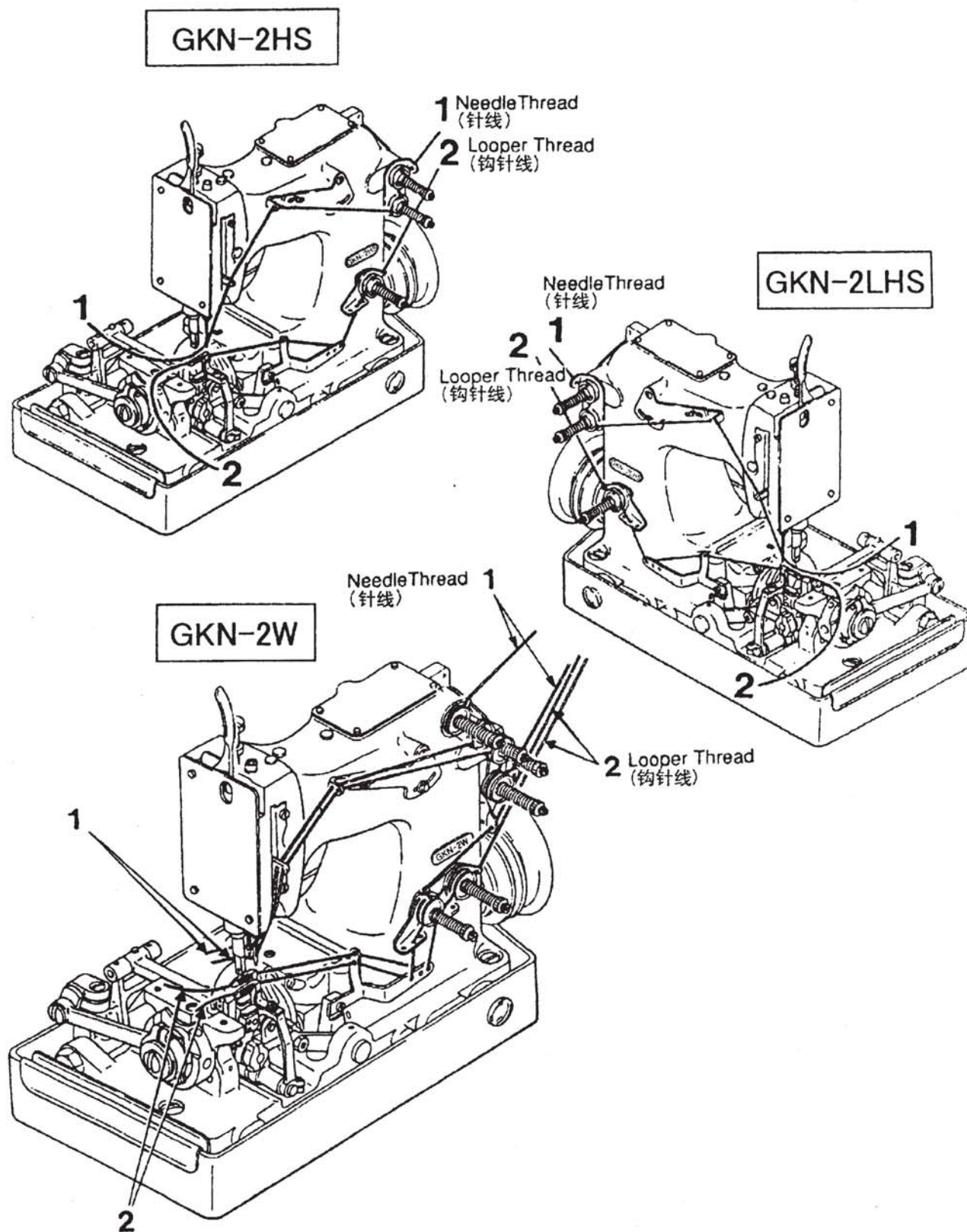
- Oil the area through which thread passes, the tension disc, the thread guide, looper, etc.
(Note:An anticorrosive agent is applied to the machines at the factory, in order to prevent rusting. It is necessary to use oil to remove this agent. or it may prevent the thread from passing smoothly.)

● 开箱后，缝袋机初次运转时，缝线通过折地方，线调整器，线导杆、钩针等务必加油。
（注意：缝袋机为了防锈于工厂出货时，经已防锈油处理。故防锈油不除去的话，缝线可能无法顺利的通过。）
- Confirm that the machine has been threaded as per the instructions 3. in the manual.

● 运转前务必详阅缝线流程的说明，确认缝线的通过是否正确。
- Confirm that the machine has been lubricated as per the instructions 4. in the manual.

● 运转前务必详读给油的说明，确认给油方法是否正确。

3. Threading/ 穿引缝线



4. Lubrication/润滑注油

All oil has been removed from your machine before shipment. Fill oil in reservoir before starting machine.

GKN-2HS 型制袋用缝袋机为自动给油型，因除油后的状态下来出货，初次运转时或长时间无运转使用时，务必将油盘注油后开始运转。

- Remove Top Cover (A). of Fig.1, and fill oil to "H" line of Oil Gauge (B). Use mineral oil of 22 to 32 cst kinetic viscosity at 40°C.
Example: Shell Tellus oil #32.

注油方法如下：

- 上盖 (A) (035481) 拆卸，注油至油表 "H" 止。注入的油为40℃，使用动黏度22CST ~ 32CST的矿油 (例) SHELL#32

- Once machine is oiled as above, further oiling is not required unless oil level goes down below line "L" of Oil Gauge. Make it a rule to check oil level before starting machine.
- To drain oil, open Cock (C). of Fig.1 Replace oil once every 2,000 hours of operation.
- When you have just received a new machine, or if machine has been stored for some time, sliding parts of machine may be dry. Following parts should be oiled by hand with an oiler:

- a) Needle Bar Bushing, upper and lower (after removing upper Face Plate (D)).
- b) Feed Lift Eccentric Ass'y (after opening Cloth Plate (E)).

- 每日运转前务必确认油表上的水平，加油一次后若未低于油表下限时，不用再加油

- 油的运转时间2,000小时交换一次，换油时打开活栓即可。

- 新的或很长时间没使用的缝袋机，其摩擦部分上油可能会消失，故务必加油。

- a) 将面板(D)(035171)拆下，针棒套管上(032151)和针棒下(032161)润滑注油。

- b) 打开底座盖送料上下组(034091A)润滑注油。

- Run the machine for about 10 minutes at a low speed to ensure that oil is distributed throughout the machine. Then proceed to the normal operation.

- 用手转动缝袋机确认是否能顺利转动后，再让缝袋机低速回转大约10分钟左右，让油充分浸润后再各部润滑注油后，再开始运转。

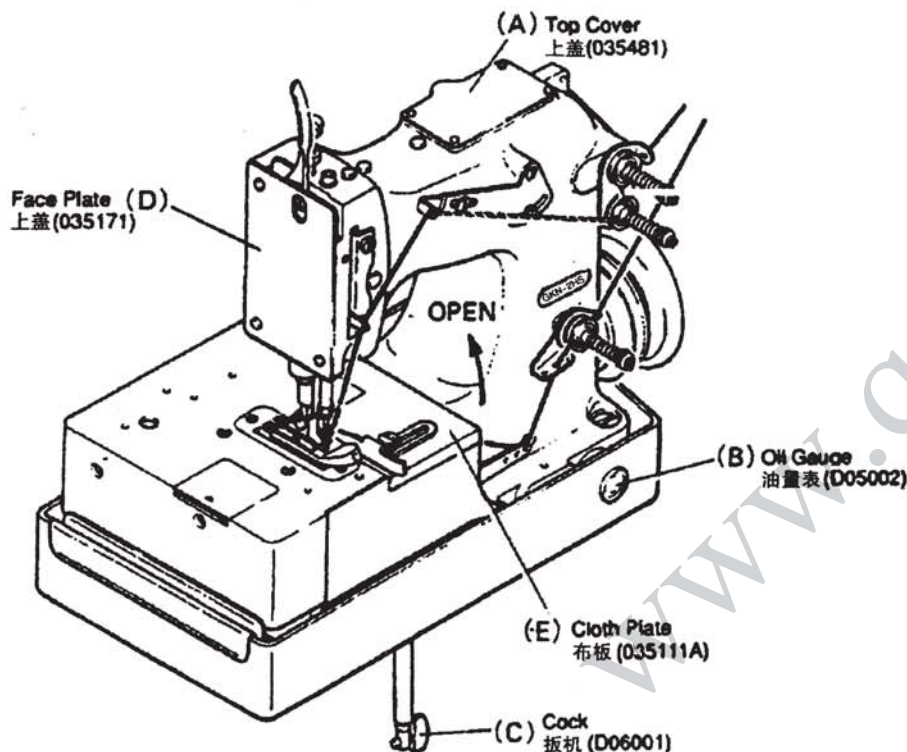


Fig.1

5. Adjustment/调整

Your machine has been properly adjusted before shipment at our plant. If, however, adjustments are required at your end due to disassembly, repair, or parts replacement, observe instructions given below.

1 LOOPER

1-1 Check of Looper Travel Distance

Looper ① travel distance, (A) of Fig.2, should be 25 to 26mm.

To adjust, loosen screw (a) and turn Eccentric Ball (c) of Looper Bell Crank Connection Rod ② clockwise with a screw driver, until correct position is obtained.

1 钩针

1-1 查看钩针移动距离

钩针①移动距离如图Fig-2所示, A:25~26mm。

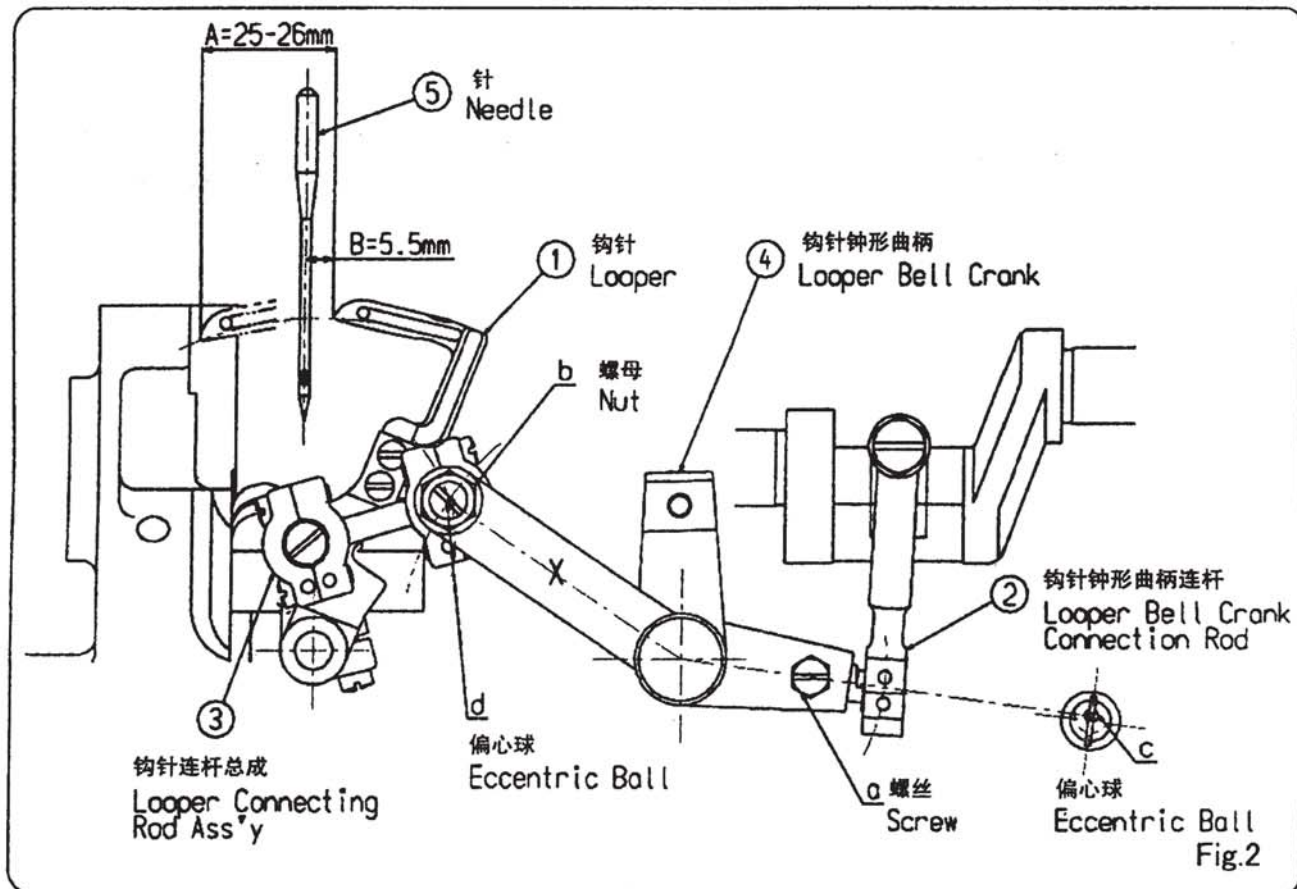
调整方法为, 松开螺丝a, 旋转钩针连杆②之偏心轮c直到正确的位置。

CAUTION

1. Measure dimension as Looper ① goes around Needle ⑤.
2. Loosen nut (b) of Fig.2, and align eccentricity of Eccentric Ball (d) of Looper Connecting Rod Ass'y③ with line (x) connecting centers of Looper Bell Crank ④ shaft and ball mounted.
Keep alignment by tentatively fastening nut (b) during above adjustment.
3. For positioning eccentricity of Eccentric Ball (c) of Looper Bell Crank Connection Rod②, turn Eccentric Ball (c), and find a position where nut (b) is placed at the highest level. Keep this position by tentatively fastening screw (a) during above adjustment.

注意事项

1. 测量钩针①到机针⑤的尺寸。
2. 将Fig-2图所示的螺母松开, 万向接头③与偏心轮d的偏心位置, 与双臂曲柄的轴心和球杆轴心连接是一条直线, 然后将螺母b拧紧。
3. 钩针连杆②的偏心球c的偏心位置, 转动偏心球, 经螺母b调整至最高位置, 然后锁紧螺丝a



5. Adjustment/调整

1-2 Check of Dimension of Needle Center to Loper point

Distance between Needle center and Loper point, (B) of Fig.2, is 5.5mm, when Loper ① is in the extreme right. To obtain this dimension, loosen nut (b), and turn Eccentric Ball (d) of Loper Connecting Rod Ass'y ③ clockwise when dimension (B) is smaller than 5.5mm, and counterclockwise when it is larger than 5.5mm.

After adjustment, check looper travel distance (A) and confirm it is in specified range of 25 to 26mm. If not adjust Eccentric Ball (c) of Loper Bell Crank Connection Rod ② again while checking dimension between Needle ⑤ center and Loper ① point, until both dimension.

1-3 Check of Height of Needle

Needle ⑤ and looper ① movements are correctly timed if distance (A and A' of Fig.3) between Loper point and Needle hole when Loper point gets in line with left-side edge of Needle ⑤ is the same as Loper ① passes Needle in forward and backward movements. $A = A' \pm 0.3\text{mm}$ is allowable. To adjust loosen screw, (a) of Fig.2, and turn Eccentric Ball (c) of Loper Bell Crank Connection Rod ② as appropriate. Loper eyelet should overlap with lower part of long hole of Needle, as shown in Fig.4 as Loper goes forward. To adjust, move Needle Bar ⑩ vertically after loosening screws (a) and (b) of Fig.5 for Needle Bar Connection ⑥ and Needle Thread Take-Up ⑦. Firmly set screws after adjustment.

CAUTION

1. To facilitate adjustment, set height of Needle point above throat plate ⑬ to 17mm, (A) of Fig.5, for DN-2HS, and 18.5mm, (B) of Fig.5, for DN-2W, with Needle Bar in its highest position.
2. Confirm proper direction of Needle ⑤ when Needle Bar ⑩ has been adjusted (Refer to Fig.13).

1-2 缝针和钩针之间的间隙

钩针①再最右侧时, 钩针①的前端距离缝针⑤的中心调整为 $B=5.5\text{mm}$, 锁紧螺母b, 若B的尺寸小于5.5mm是, 将方向接头的偏心球向右回转, 反过来大于5.5mm时, 向左回转来调整。

然后再次确认钩针的移动量A是否为25-26mm, 移动量若未达到25-26mm范围时, 再次转动钩针连杆②的偏心球来确认其移动量, 再确认缝针⑤的中心到钩针①前端的尺寸。依指示尺寸调整钩针①的移动量(A)与缝针中心到钩针前端的尺寸。

1-3 缝针高度

钩针①向左或向右转动时, 缝针⑤的左侧面与钩针前端一致时, 如图所示Fig.3。钩针①前端到针孔的尺寸 $A=A'$ 时, 缝针与钩针同步。 $A=A' \pm 0.3\text{mm}$ 为允许范围。钩针与缝针同步以及允许访问未达到时, Fig.2的螺丝松开, 转动钩针连杆②的变心球来调整。然后钩针①前进时, 对于钩针与针孔是否一致, 如图所示Fig.4, 调整针棒⑩与钩针孔, 针棒⑩上下调整, 如图Fig.5, 松开针棒座⑥和上线线导⑦的螺丝来调整, 调整后锁紧螺丝。

注意事项

1. 针棒来到最上面时, 如图所示Fig.5, GKN-2HS型号针棒若离针板⑬ $A=17\text{mm}$, GKN-2W型号针棒若离针板⑬ $B=18.5\text{mm}$ 时, 调整较容易。
2. 针棒⑩上下转动时, 务必注意缝针的方向

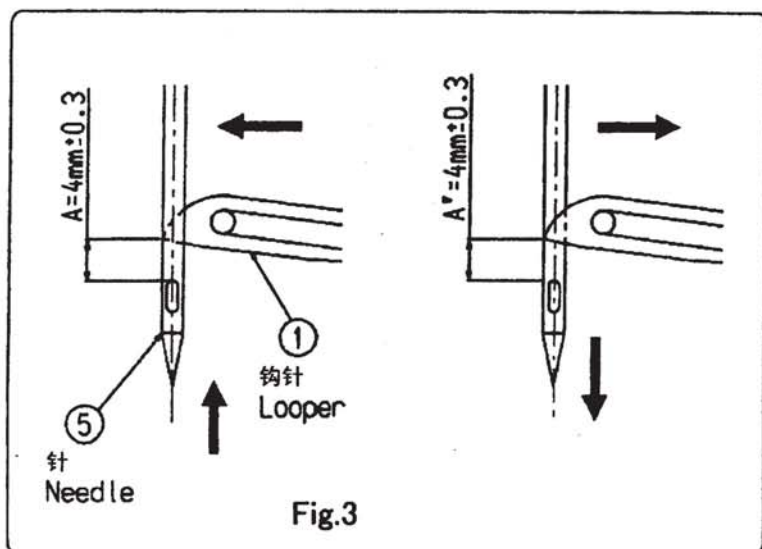


Fig.3

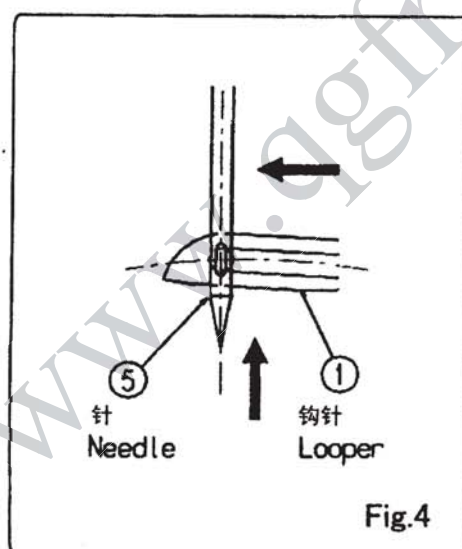


Fig.4

5. Adjustment/调整

1-4 Clearance between Needle and Loper

Clearance between Needle ⑤ and Loper ① is 0(zero) to 0.05mm as Loper passes far side of Needle in its forward travel, as shown in Fig.6. In no case, Loper should hit Needle. To adjust, loosen screw (a) of Loper Rocker Shaft Crank ⑧.

Clearance between Needle and Loper as Loper passes this side of Needle in its backward movement should be 0.05 to 0.5mm Loper Avoid Eccentric Cam ⑨ is used for adjustment. Slant of Loper can be increased by turning Loper Avoid Eccentric Cam ⑨ in direction of 'X' (Fig.7), and decreased by turning it in direction of 'Y'.

CAUTION

To facilitate adjustment, first adjust Loper Avoid Eccentric Cam ⑨ so that its set screw (a) is located as 45°, as shown in Fig.7, when nut (b) of Fig.2, is in its highest position.

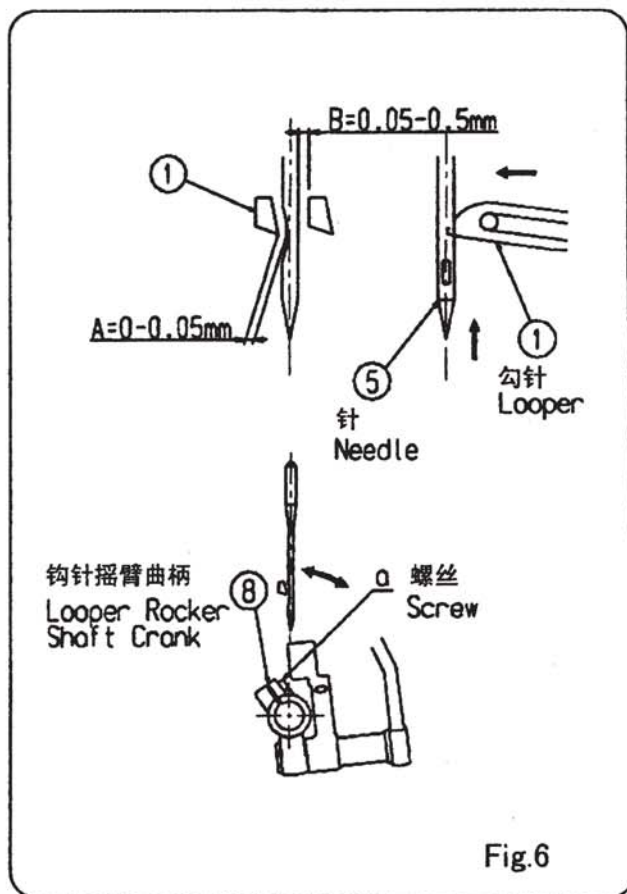
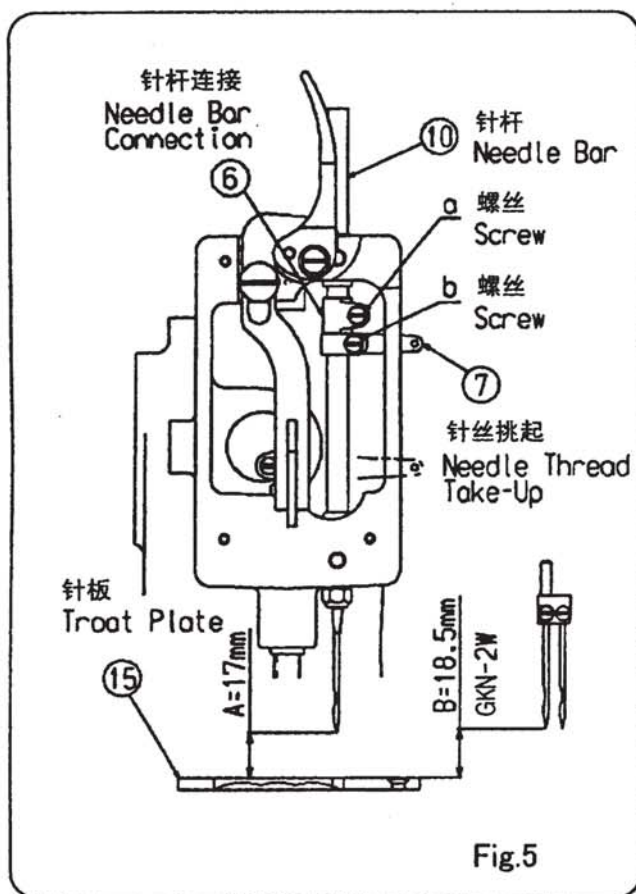
1-4 缝针与钩针的间隙调整

缝针与钩针的间隙如图所示Fig.6, 钩针①的前端, 滑过缝针⑤的后面时, 调整与缝针的间隙为 $A=0-0.05\text{mm}$ 勿碰撞到针的后面。

把钩针基座⑧的螺丝松开调整, 钩针千金向右移动时, 针与钩针的间隙最接近时, 调整为 $B=0.05-0.5\text{mm}$.调整偏心轮⑨ 如图Fig.7, 把偏心轮⑨往X方向转动则钩针的移动量大, 反之Y方向则移动量小。

注意事项

调整偏心轮⑨的 Fig.5 螺母b在最高位置时, 如图Fig.7 偏心轮的调节螺丝a到45度位置时, 调整较容易。



5. Adjustment/调整

2 FEED MECHANISM

2-1 Positioning of Feed Lift Eccentric Cam

Loosen set screw of Feed Lift Eccentric Cam ⑪ of Fig.8, and place eccentricity of Feed Lift Eccentric Cam ⑪ at its highest position, or Feed Dog ⑫ to its maximum height, when Needle Bar ⑩ is in highest position. Firmly tighten set screw (a) after adjustment.

2-2 Needle Guide and Loop Retainer

Loosen set screw, (a) of Fig.9, of Needle Guide ⑬, and adjust Needle Guide ⑬ so that clearance between Needle and Needle Guide (clearance 'A' of Fig.9) is 0(zero)mm, as Needle goes up. Firmly tighten set screw (a) after adjustment. Be sure that Needle Guide will not push Needle. Turn pulley by hand to confirm that Needle Guide does not push Needle. (If Needle Guide pushes Needle, Needle may break during operation.)

Loosen set screw, (b) of Fig.9, of Loop Retainer ⑭, and adjust Loop Retainer ⑭, so that clearance between Needle and Loop Retainer (clearance 'B') is 0.05 to 0.1mm. Firmly tighten set screw (b) after adjustment.

2 送料机构的调整

2-1 送料上下轮的位置

针杆⑩位于最高点时, 如图所示Fig.8, 送料上下轮⑪的偏心位置位于最高点, 也就是送料齿⑫位于针板上面最高点时, 锁紧送料轮之调节螺丝a。

2-2 针导杆及环状导杆的调整

针导杆⑬与环状导杆的关系, 针由最下面的位置上升时, 如图所示Fig.9, 松开螺丝a来调整针导杆⑬, 针与针导杆的间隙调整为A=0mm, 然后锁紧螺丝a。这个时候, 请转动滑轮确认针导杆是否碰到针, 若缝针被压到, 将造成针折断。

环状导杆⑭的调整, 松开调节螺丝b, 调整针与环状针导的间隙为0.05-0.1mm, 然后锁紧螺丝b。

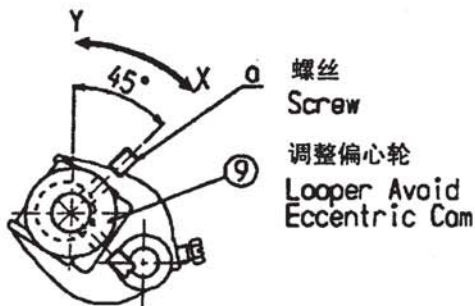


Fig.7

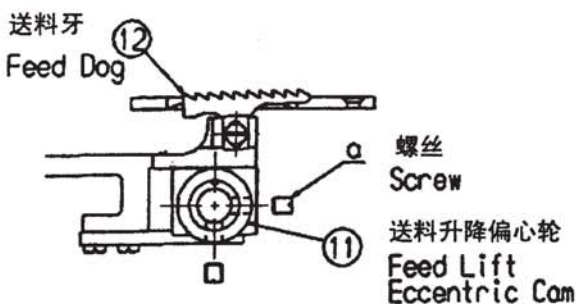


Fig.8

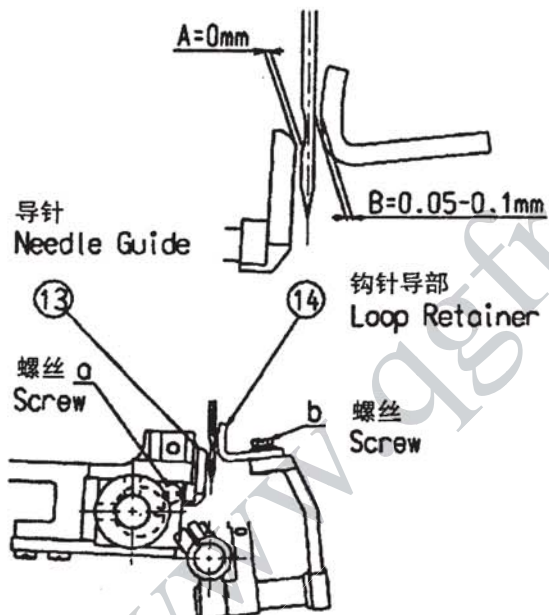


Fig.9

5. Adjustment/调整

2-3 Feed Dog

Clearance between end of Feed Dog ⑫ and grooves of Throat Plate ⑮ must be uniform both in crosswise and longitudinal directions, as shown in Fig.10, when Feed Dog ⑫ is set to a specified stitch length within its adjustable range.

Feed Dog ⑫ teeth on trailing edge should protrude above Throat Plate ⑮ by 1.8 to 2.0mm (dimension 'C' of Fig.10), when Feed Dog is in its highest position. Detail of required adjustments is as follows:

a) Adjustment in Crosswise Direction

Loosen nut, (d) of Fig.11, of Feed Dog ⑫, and adjust position of Feed Rocker ⑮ so that $A=A'$ is obtained. Tighten nut (d) and confirm that Feed Rocker ⑮ moves smoothly.

b) Adjustment in Longitudinal Direction

Adjust Feed Drive Eccentric Cam ⑰ with its adjust screw, (a) of fig.11, so that feed amount of Feed Dog ⑫ is 10mm. To adjust, loosen screw, (b) of Fig.11, of Feed Drive Eccentric Cam, ⑰ and turn adjust screw (a) counterclockwise to increase feed amount, and clockwise to decrease it.

Clearance (B) between Feed Dog ⑫ and grooves of Throat Plate ⑮ when Feed Dog is in extreme backward position should be equal to clearance (B') between them when Feed Dog is in extremely advanced position. For this clearance adjustment, loosen screw (c) of Feed Rocker ⑮, and turn screw (e) as appropriate.

c) Height Adjustment

Adjust height of screw, (a) of Fig.10, so that Feed Dog ⑫ teeth on trailing edge are 1.8 to 2.0mm high above Throat Plate ⑮ ('C' of Fig.10) when Feed Dog is at its highest position. Firmly set Feed Dog in position by tightening screw (b).

When Feed Dog makes scratches on the crepe tape, set Feed Dog a bit higher.

2-3 送料牙的调整

如图Fig.10所示,当送料牙在可调节范围内调整到指定长度时,送料牙末端和针板沟槽的间隙必须在横纵方向保持一致。

当送料牙在最高位置时,送料齿边缘位置时,应该超出针板1.8-2.0mm(如图Fig.10所示的C尺寸)具体调整如下:

a) 左右调整

送料牙的左右调整,松开d螺母(如图Fig.11),将送料基座⑩左右移动,调整为 $A=A'$,并锁紧螺母d,然后确认送料基座是否顺利工作。

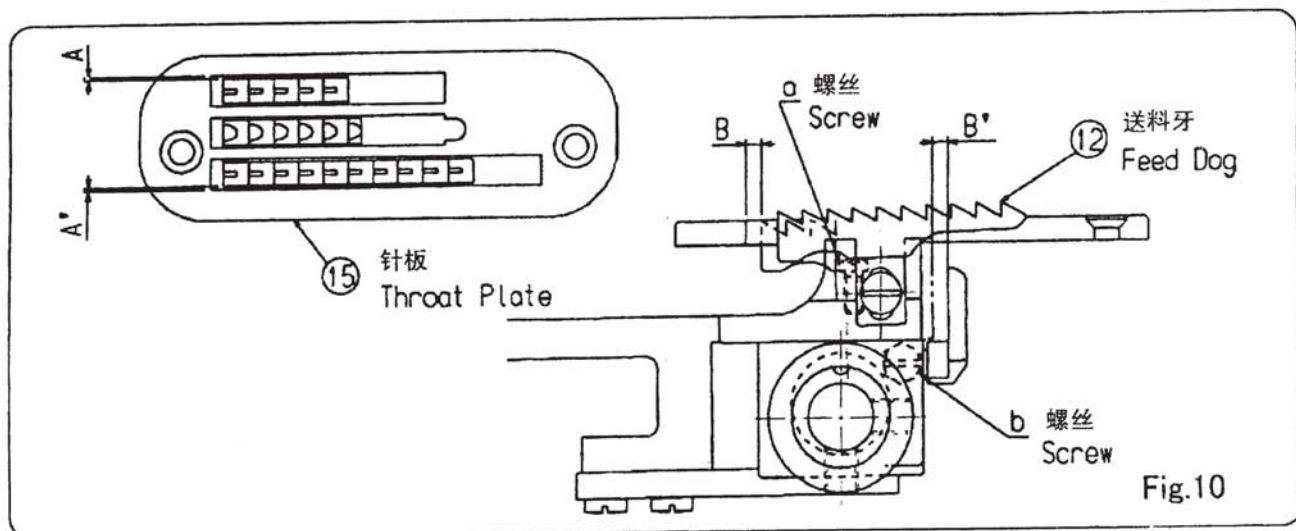
b) 前后调整

调整送料偏心轮⑰的螺丝a,让送料齿的送料量为10mm,送料量的调整如图Fig.11所示。松开送料偏心轮⑰的螺丝b之后,调整螺丝a向左回转则送料量大,反之向右回转则送料量小。

然后松开送料基座⑩的螺丝c,调节螺丝e,调整送料齿⑫向后到末端,针板沟槽与送料齿的间隙B,与向前时的送料基座和针导杆之间的间隙B'为同距。

c) 上下调整

送料齿的高度如图Fig.10所示,送料齿位于最高位置时,调整螺丝a的高度,让送料齿的后侧离针板的距离是 $C=1.8-2.0mm$,然后锁紧螺丝b,缝制时若有送料齿刻痕时,则送料齿的位置过高。



5. Adjustment/调整

2-4 Change of Stitch Spacing

Standard setting of stitch spacing of your machine is 10mm (when paper bags were specified) for DN-2HS, and 8mm for DN-2W. When changing standard stitch spacing at your end, observe following procedures:

Loosen screw, (b) of Fig.11 of Feed Drive Eccentric Cam ⑰, and turn adjust screw (a) counterclockwise to enlarge stitch spacing, and clockwise to reduce it. Tighten screw (b) tentatively, and run several pieces of material to test to confirm that you get required stitch spacing. Finally, fasten screw (b) firmly.

2-4 缝距的调整

GKN-2HS制袋缝纫机在出货时，用于纸袋时缝距调整为10mm，用于PP编织袋时，调整为8mm。GKN-2W的缝距为8mm。如果需要调整缝距，其调整顺序为：

松开送料偏心轮的螺丝b，转动并调整相应的调节螺丝a。调节螺丝向左转则缝距变大，反之向右转缝距变小。将螺丝b暂时锁紧并试缝，确认试缝袋是否符合要求，之后在紧固螺丝b。

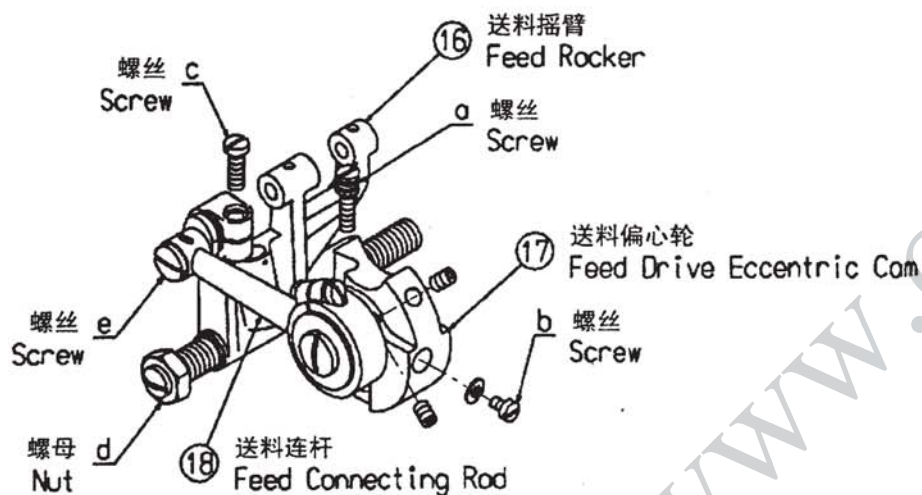


Fig.11

5. Adjustment/调整

4 Needle

1) Needle Size

Available needle size includes DR×2 #25, DN×1 #25, etc. Your machine is provided with DR×2 #25 needle. When you have changed the needle size, positional adjustment of looper must be carried out.

- 2) A bent or damaged needle results in thread break, skipping stitches, and other troubles. Replace it with a new one in the steps below. Install a new needle referring to figures 13 and 14. To remove the needle, turn pulley by hand until the needle bar reaches its highest position. Turn the needle clamp nut in the arrow mark using the spanner included in the accessory. You can now remove the needle from the needle bar. Two important points must be observed when you install a new needle.

- The shaved part of the needle must face the leading direction of the machine (Fig.13).
- Push the needle in the needle bar as deep as it will go.
- When you have installed the needle, tighten the needle clamp nut firmly.
- For DN-2W install needles in the needle holder, and secure them with screws.

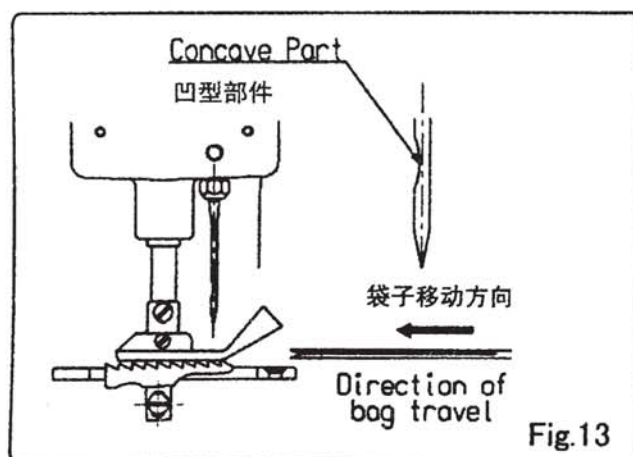


Fig.13

Caution:

Thread may break or skip if the needle is not correctly installed or it is bent or damaged. Install a new needle correctly. To check if the needle is bent or not, simply roll it on a flat surface such as a pane of glass.

5 Throat Plate

The throat plate is constantly subject to pressure given by presser foot, and may be bent in due course of operation. If the throat plate is bent, it may be hit by feed dog teeth, resulting in a machine trouble. To replace, loosen set screws.

4 缝针

1) 缝针的尺寸

缝针尺寸可分为 DR×2#25, DR×1#25等。

此缝纫机配有 DR×2#25号缝针, 当改变缝针的尺寸时, 也必须调整钩针的位置。

- 2) 缝针弯曲或损失将引起断线或跳针, 请参照Fig.13/14更换机针。要取下缝针, 需要用手转动皮带轮, 直到缝针杆达到最高位置。使用随机提供的附件包中的扳手, 在箭头方向上转动缝针夹。此时, 你可以从针杆上取下缝针。

安装新针时, 必须遵守如下几点:

- 缝针的凹陷部位必须面向机器的前方(图.13)。
- 把缝针尽量深的推入针杆中。
- 已经安装了缝针时, 拧紧缝针夹螺母。
- GKN-2W型号, 将机针推入针座, 在锁紧螺丝。

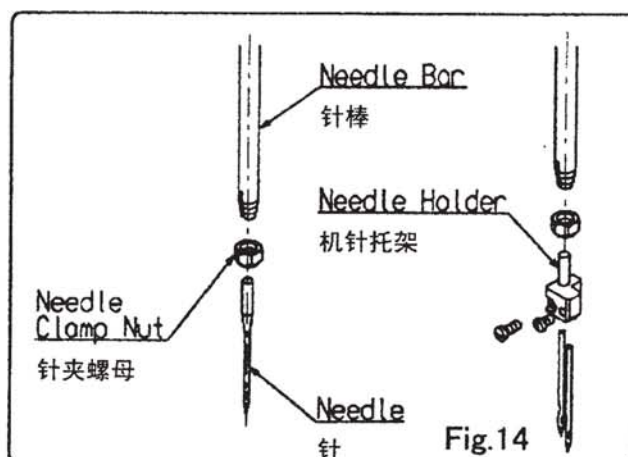


Fig.14

[当心]

如果针未正确安装, 可能会断线或跳线, 或者, 它会弯曲或损坏。正确地安装新针。检查针是否弯曲, 简单地把弯曲的针在平面上翻转便可, 比如在一块玻璃上。

5 针板

针板是经常承受压脚上面的压力, 时间长之后针板中间将会弯曲, 如果针板弯曲, 碰触送料齿的沟槽, 会造成故障。因此必须更换新的针板, 更换时, 将针板上的2个螺丝松开, 并取下针板。安装之后, 无比锁紧螺丝。

5. Adjustment/调整

6 ADJUSTMENT FOR SINGLE THREAD SEWING

6-1 Distance between Loooper and Needle

Distance between Needle center and Loooper point is 5 mm, when Loooper is in the extreme right.

To obtain this dimension, loosen nut (A).

Loooper travel distance should be adjusted at 24mm by loosening screw (B). (Fig.15)

6 单线缝制的调整

6-1 缝线与钩针的距离

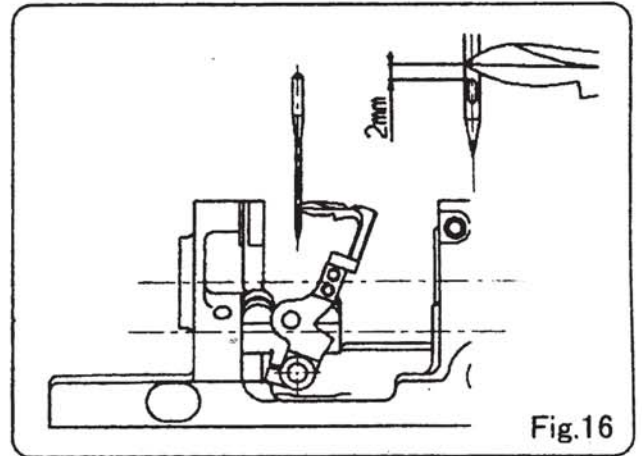
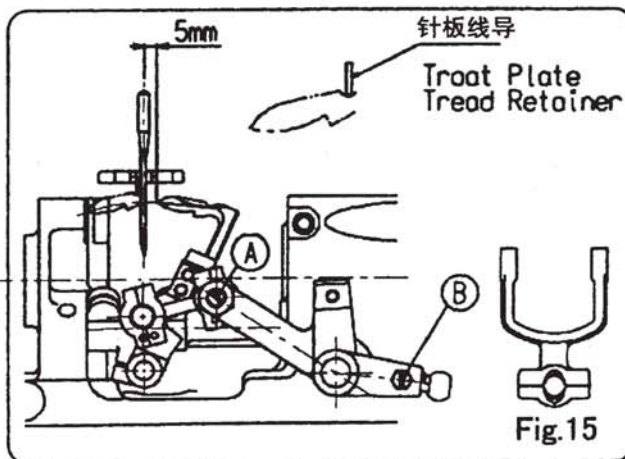
钩针位于最后位置时, 松开螺母(A), 调整钩针与缝针的中心距离为5mm。松开螺丝(B), 钩针活动距离调整为24mm (如图.15)

6-2 Check Height of Needle Bar

Adjust the height of Needle Bar to have distance of 2mm between Loooper point and Needle Hole when Loooper point gets in line with left-side edge of Needle in forward and backward movements. (Fig.16)

6-2 检查针杆高度

钩针前端位于缝针的左侧面时, 调整针杆高度, 让针孔上部至钩针前端的距离为2mm (如图.16)



6-3 Fixing Throat Plate Thread Retainer

Fix Thread Retainer at Throat Plate, keeping it having 1.1mm clearance from Needle point. When Needle is sinking into the loop, Loope Guide helps to spread the loop for successful stitching. (Fig.17)

6-3 针板爪的安装

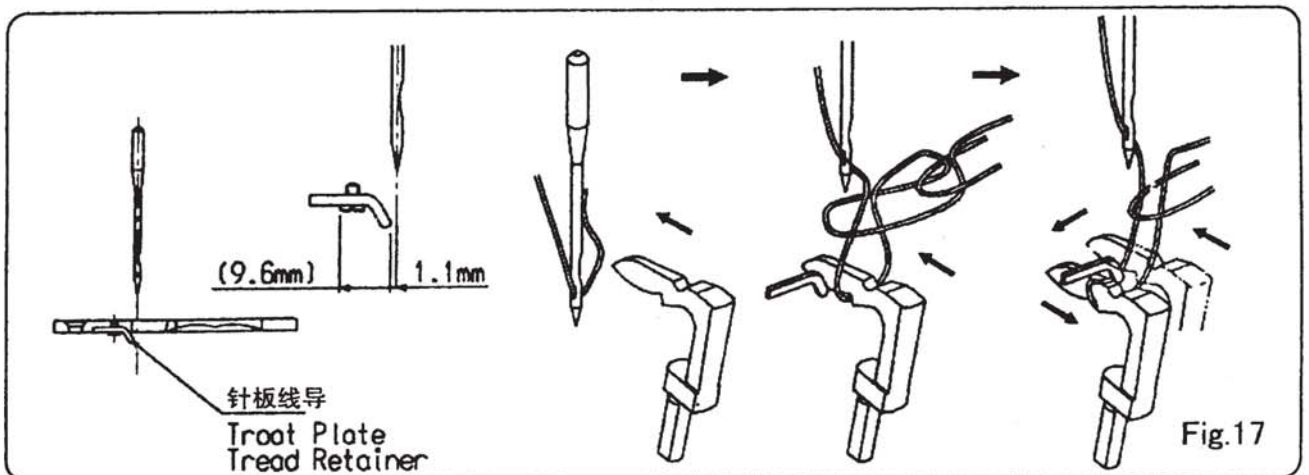
调整针板爪至缝针中心线的距离为1.1mm, 针板爪是缝针进入环状时, 钩针线导防止跳针 (如图.17)

6-4 Check of Loooper Travel Distance

When a escape ditch of a looper goes along a bottom of a needle board nail, Loosen screw B not come into contact a looper, and please decide a momentum of a looper.

6-4 检查钩针的活动量

钩针通过针板爪的下面时, 钩针不能被碰触到, 松开螺丝B, 决定钩针的活动量。



5. Adjustment/调整

7 ADJUSTMENT FOR THE UPPER FEEDING

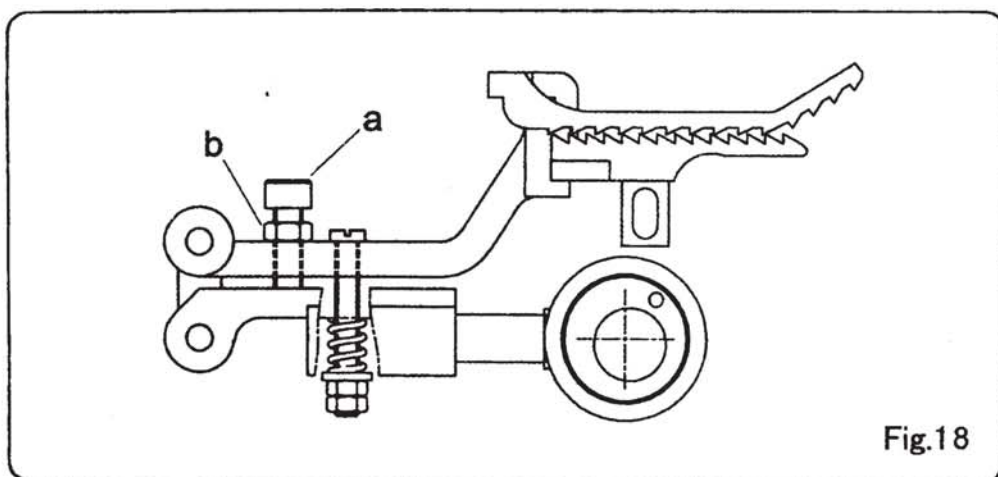
Adjust the height to the Upper Feed Dog by Screw (a) on the Upper Feed dog holder to keep the teeth parallel to each on the Upper Feed Dog and Feed Dog when the Feed Dog is in its highest position. Then fix it by Nut (b). (Fig.18)

Next, raise the Upper Feed Dog up to fit the Feed Dog is in its highest position.

7 上送料牙的调整

通过调整上牙架上的螺钉（a），调整至上牙齿的高度，以便当机牙在最高位置时，保持上牙和机牙上的各个齿牙平行。再通过螺母（b）固定好。（图18）

接下来，当机牙在最高位置时，把上牙齿提高，以适应机牙齿。



6. Troubleshooting

When trouble occurs while operating the machine, refer to the following table for selecting suitable measures:

Trouble	Cause	Cure
Needle thread breaks	1. Damaged looper 2. Needle thread too tight 3. Worn out feed dog causing fine stitches 4. Thread twisting or entangling between thread stand and needle 5. Improper needle setting; Bent or damaged needle 6. Needle thread too loose	Replace looper. Reduce tension. Replace feed dog. Secure correct threading. Set needle properly; Replace needle. Increase tension.
Looper thread breaks	1. Looper thread too tight or too loose 2. Damaged looper 3. Thread twisting or entangling between thread stand and looper	Adjust tension. Replace looper. Check for correct threading.
No chaining on work edges	1. Incorrect threading 2. Looper thread too tight 3. Improper timing of needle and looper 4. Presser foot screw loosened	Thread machine correctly. Reduce tension. Adjust timing of needle and looper. Tighten the screw.
Thread skips	1. Needle setting not correct; Bent or damaged 2. Needle thread regulator set too low. 3. Needle thread sticking on needle due to heat 4. Needle bar set 5. Needle thread pinched by needle guard, collapsing loop 6. Looper thread too loose, not making a good triangle	Set needle correctly. Replace needle. Raise regulator. Use lubricant on thread. Lower needle bar. Lower needle guard slightly. Increase looper thread tension.
Needle or looper breaks	1. Improper timing of needle and looper 2. Bent needle	Adjust timing of needle and looper. Replace needle.
No uniform stitch length; seam not straight.	1. Weak pressure of presser foot 2. Bent needle 3. Worn out feed dog	Increase pressure. Replace needle. Replace feed dog.

6. 故障排诊断和应对方法

在运行机器的过程中，当故障发生时，请参考下表选择合适的措施。

故 障	原 因	措 施
缝针线断线	1. 钩针受损。 2. 针线太紧。 3. 进料齿磨损，导致针距过短。 4. 线架和缝针之间的线纠缠到一起或缠住。 5. 缝针的设置不当；针弯曲或受损 6. 缝针线太松。	更换钩针。 减小张力。 更换进料齿。 固定正确的缝线。 正确地设置针；更换缝针。 增大张力。
钩针线断线	1. 钩针线太紧或太松 2. 钩针受损。 3. 线架和针之间的缝线纠缠到一起或缠住。	调整张力。 更换钩针。 检查线是否正确。
缝合后无法形成结线	1. 穿线不对。 2. 钩针线太紧。 3. 缝针和钩针互相动作不合。 4. 压脚螺钉松动。	线调对。 降低张力。 调整针和钩针。 拧紧螺钉。
跳线	1. 缝针设置不对；弯曲或受损 2. 缝针线调节器设置太低。 3. 因发热，缝针线和缝针紧贴在一起。 4. 缝针杆设置。 5. 缝针线被缝针套夹住。弄坏钩针 6. 钩针线太松，未形成一个良好的三角形。	把缝针设置正确。更换缝针。 升高调节器。 缝线上使用润滑剂。 降低缝针杆。 轻轻地降低针套。 增大钩针线张力。
缝针或钩针断裂	1. 针和钩针互相动作不合。 2. 针弯曲	调整针和钩针 换针。
针距范围不均， 缝不直	1. 压脚压力小。 2. 缝针弯曲。 3. 进料齿磨损。	增大压力。 更换缝针。 更换进料齿。

ORDERING PARTS

1. Description of each part and its stamp number is described in this parts list. Screws and nuts for parts are shown adjacent to the relevant parts. When ordering parts, describe clearly stamp number with its name of part.
 2. The parts which have no Ref. Number can not be delivered independently; always order it as an assembly.
 3. A set of assembled parts is represented by the stamp number of its main parts.
 4. The last figure on the parts stamp number advances on each improvement of the parts.
 5. Parts No. described in [] of Remarks means old parts No.
- The parts list is subject to change without prior notice.

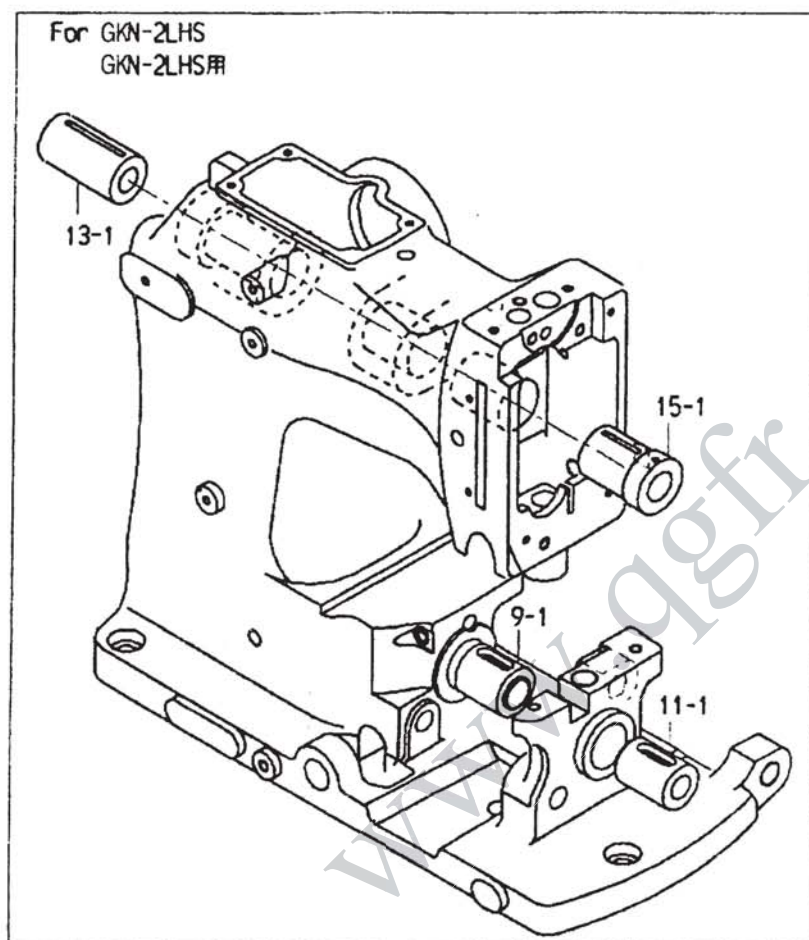
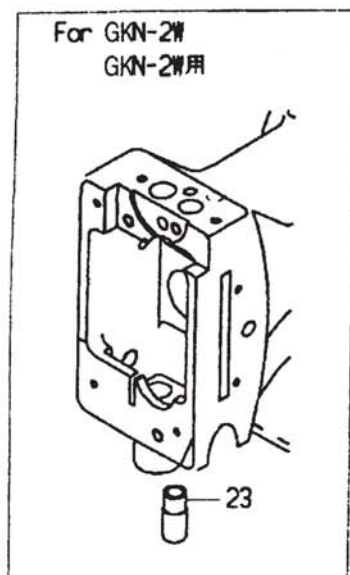
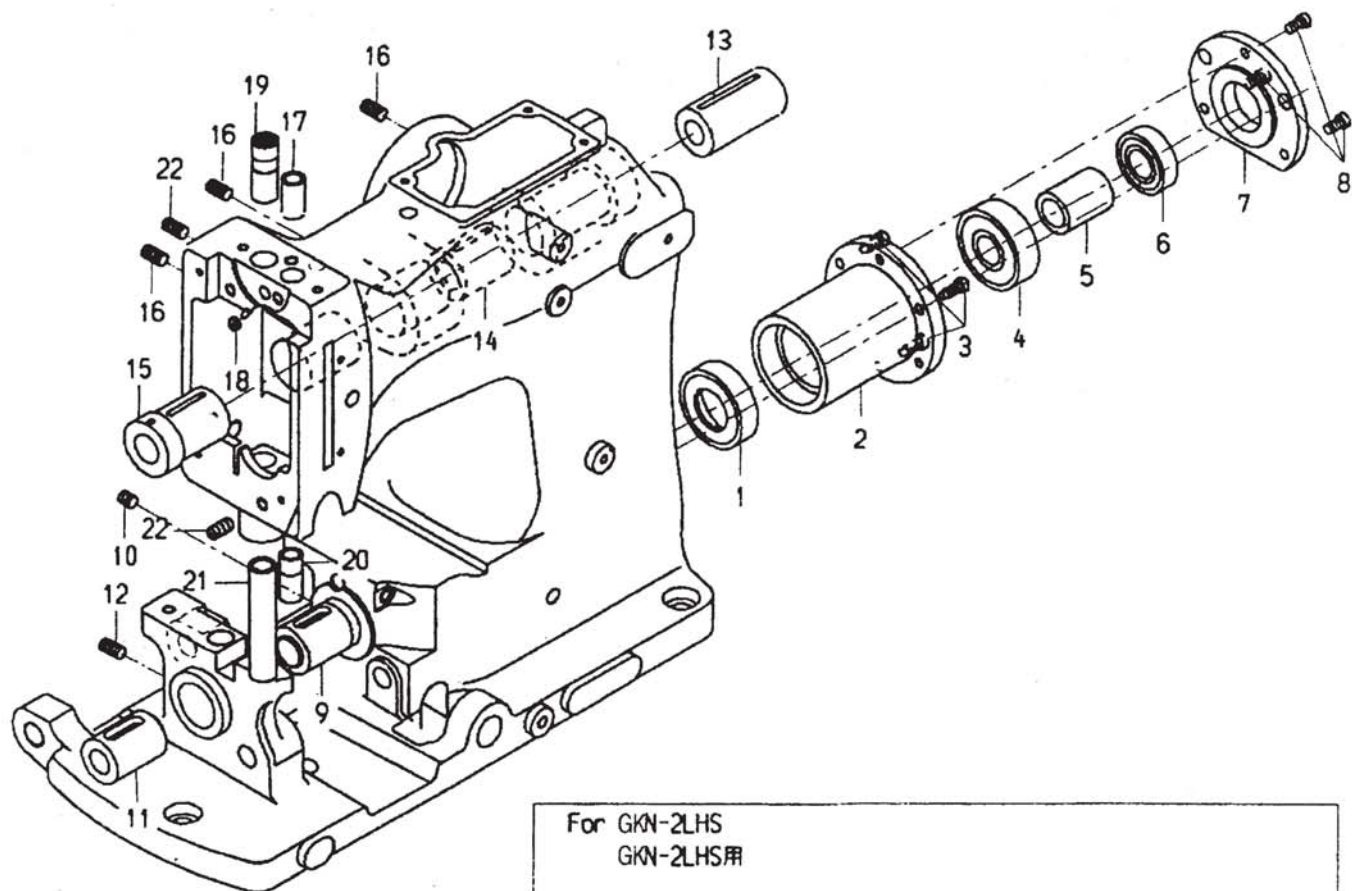
订购零件

1. 每个零件及其零件标记号的零件名称均在本零件清单中加以描述。零件的螺钉和螺母紧挨在相应零件处显示。
 2. 当订购零件时，应弄清零部件标记号和零部件名称。
 3. 无参考编号的零件不能单独发货，这些零件必须作为组装件一起订货。
 4. 一组装配好的零件将按其主要零件的标记号供货。
零件标记编号的最后一位数按零件的改进次数依次递增。
 5. 备注中[]中的零件编号指组装件编号。
- 零件清单会随时变化，恕不另行通知。

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01. BUSHING PARTS 轴套部件

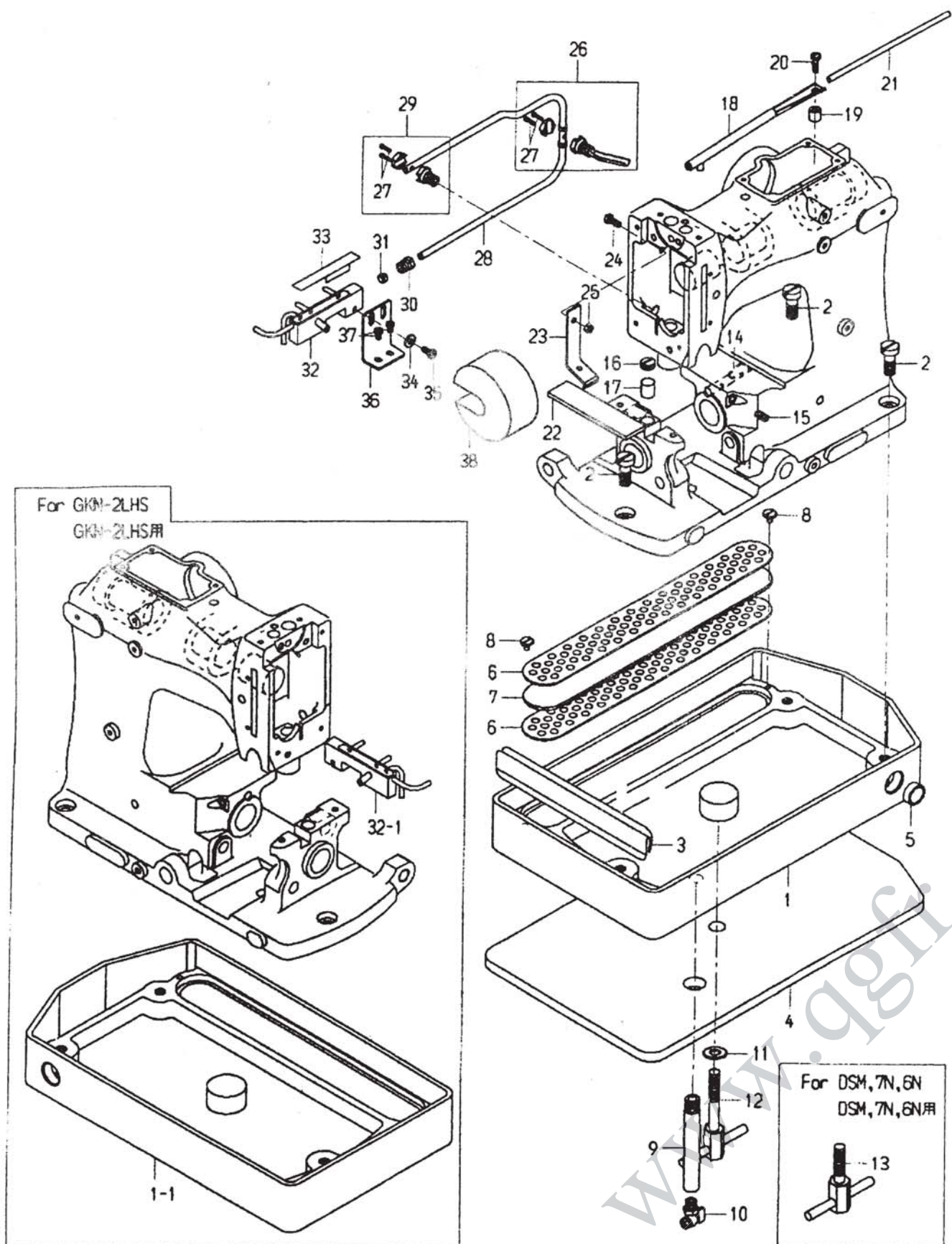


01. BUSHING PARTS

轴套部件

参考编号 Ref. No.	零部件号码 Part No.	零件名称 Description	数量 Q'ty					备注 Remarks
			-2HS	-2LHS	-2W	-2U	-2LU	
1	D04003	Oil Seal (SC224211)	油封	1	1	1	1	1
2	031082	Crank Shaft Bushing Housing	曲轴衬套外壳	1	1	1	1	1
3	3/16S28017	Screw for 031082	螺钉	3	3	3	3	3
4	1A01004	Ball Bearing (6202ZZ)	球轴承	1	1	1	1	1
5	031111	Collar A	轴环	1	1	1	1	1
6	1A01002	Ball Bearing (6302ZZ)	球轴承	1	1	1	1	1
7	031091	Bearing Holder	轴承托架	1	1	1	1	1
8	3/16S28014	Screw for 031091	螺钉	3	3	3	3	3
9	031073	Crank Shaft Bushing, middle	曲轴衬套, 中间	1	-	1	1	-
9-1	041033	Crank Shaft Bushing, middle	曲轴衬套, 中间	-	1	-	-	1
10	15/64S28513	Screw for 031073,041033	螺钉	1	1	1	1	1
11	031063	Crank Shaft Bushing, front	曲轴衬套, 前	1	-	1	1	-
11-1	041043	Crank Shaft Bushing, front	曲轴衬套, 前	-	1	-	-	1
12	15/64S28516	Screw for 031063,041043	螺钉	1	1	1	1	1
13	032081	Arm Rocker Shaft Bushing, rear	摇臂轴衬套, 后	1	-	1	1	-
13-1	042031	Arm Rocker Shaft Bushing, rear	摇臂轴衬套, 后	-	1	-	-	1
14	032071	Arm Rocker Shaft Bushing, middle	摇臂轴衬套, 中	1	1	1	1	1
15	032061	Arm Rocker Shaft Bushing, front	摇臂轴衬套, 前	1	-	1	1	-
15-1	042021	Arm Rocker Shaft Bushing, front	摇臂轴衬套, 前	-	1	-	-	1
16	15/64S28516	Screw for 032081,042031,032071 032061,042021	螺钉	3	3	3	3	3
17	032151	Needle Bar Bushing, upper	针杆衬套, 上	1	1	1	1	1
18	15/64S28501	Screw for 032151	螺钉	1	1	1	1	1
19	032201	Presser Bar Bushing, upper	压杆衬套, 上	1	1	1	1	1
20	032161	Needle Bar Bushing, lower	针杆衬套, 下	1	1	-	1	1
21	032211	Presser Bar Bushing, lower	压杆衬套, 下	1	1	1	1	1
22	15/64S28516	Screw for 032161,032201,092062	螺钉	2	2	2	2	2
23	092062	Needle Bar Bushing, lower	针杆衬套, 下	-	-	1	-	-

02. OILING PARTS 润滑装置零件

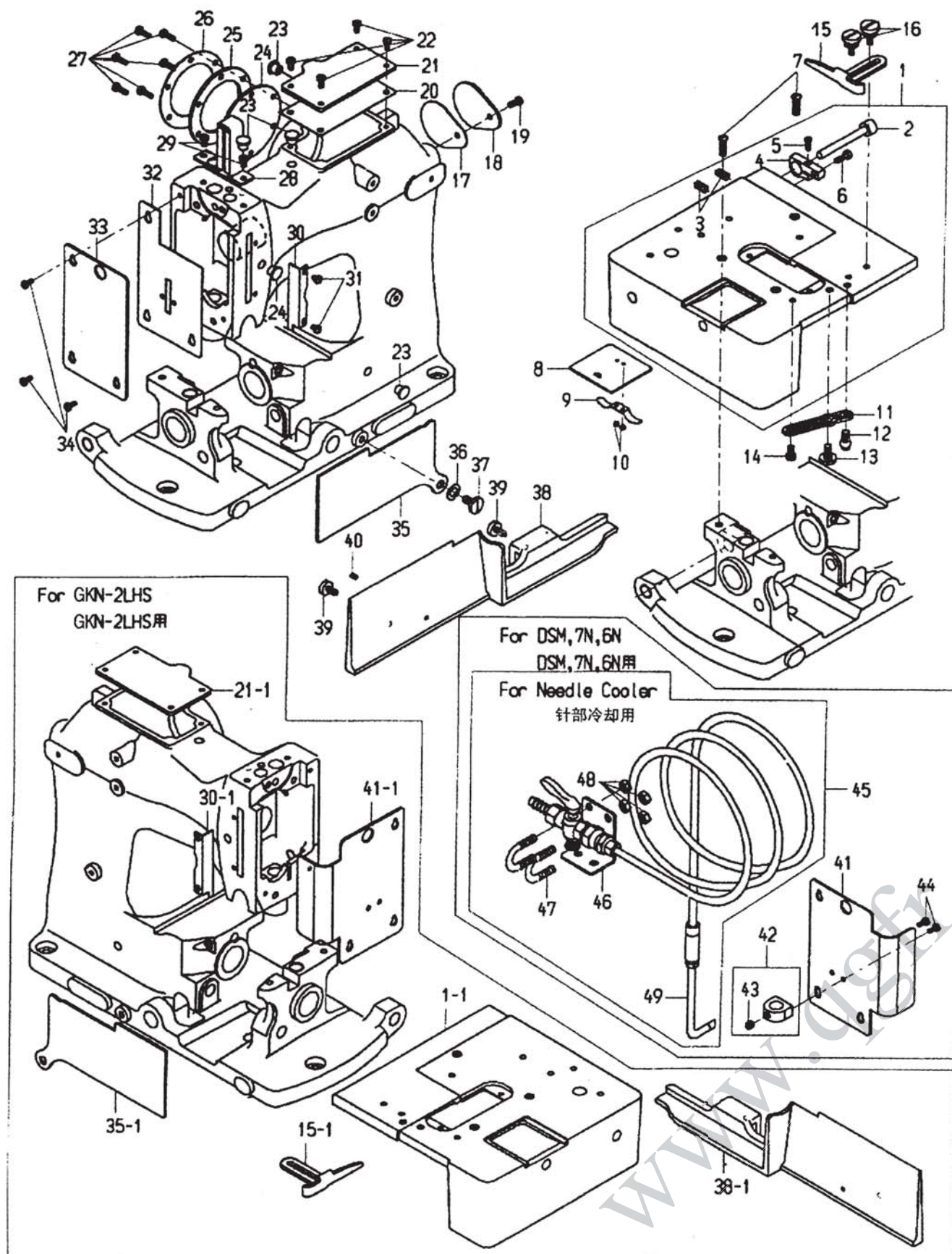


02. OILING PARTS

润滑装置零件

参考编号 Ref. No.	零部件号码 Part No.	零件名称 Description	数量 Q'ty					备注 Remarks	
			-2HS	-2LHS	-2W	-2U	-2LU		
1	035251	Oil Pan	油底壳	1	-	1	1	-	for DSM,7N,6N
1-1	045071	Oil Pan	油底壳	-	1	-	-	1	
2	W3/8S16001	Screw for 035251,045071	螺钉	3	3	3	3	3	
3	035302	Dust Cover	防尘盖	1	1	1	1	1	
4	035741	Rubber Pad	防震垫	1	1	1	1	1	
5	D05002	Oil Gauge (HL VA-01)	油位计	1	1	1	1	1	
6	035282	Oil Filter Cover	滤油器盖	2	2	2	2	2	
7	035291	Oil Filter	滤油器	1	1	1	1	1	
8	3/16S32023	Screw for 035281	螺钉	2	2	2	2	2	
9	015151	Oil Pipe	油管	1	1	1	1	1	
10	D06001	Cock (PF1/8)	旋塞	1	1	1	1	1	
11	2W10	Washer for 015141,015142	垫圈	1	1	1	1	1	
12	015141	Oil Pan Fixing Screw	油底壳固定螺钉	1	-	1	1	-	
13	015142	Oil Pan Fixing Screw	油底壳固定螺钉	(1)	1	-	(1)	1	
14	035381	Oil Pipe	油管	1	1	1	1	1	
15	15/64S28516	Screw for 035381	螺钉	1	1	1	1	1	
16	1/2S24501	Screw	螺钉	1	1	1	1	1	
17	035721	Felt	牛毛毡	1	1	1	1	1	
18	035921	Oil Pipe	油管	1	1	1	1	1	
19	182271	Collar	旋塞	1	1	1	1	1	
20	11/64S40072	Screw for 035921	螺钉	1	1	1	1	1	
21	035931	Felt	牛毛毡	1	1	1	1	1	
22	035651	Felt	牛毛毡	1	1	1	1	1	
23	035271	Holder	托架	1	1	1	1	1	
24	11/64S40010	Screw for 035271	螺钉	1	1	1	1	1	
25	11/64N40201	Nut for 035271	螺母	1	1	1	1	1	
26	035321A	Coupling and Oil Pipe	联轴器和油管	1	1	1	1	1	
27	3/32S56006	Screw for 035321A, 035321	螺钉	4	4	4	4	4	
28	035312	Oil Pipe	油管	1	1	1	-	-	
29	035321	Coupling	联轴器	1	1	1	1	1	
30	D07006	Compression Bushing (M6252-6)	压缩衬套	1	1	1	-	-	
31	D07008	Compression Sleeve (M6254-6)	压缩套筒	1	1	1	-	-	
32	035631	Oiler	注油辅助	1	-	1	-	-	
32-1	045161	Oiler	注油辅助	-	1	-	-	-	
33	035661	Cover	盖板	1	1	1	-	-	
34	11/64W15103	Washer	垫圈	1	1	1	-	-	
35	11/64S40009	Screw	螺丝	1	1	1	-	-	
36	0354343	Cover	盖板	1	1	1	-	-	
37	11/64S40005	Screw	螺丝	2	2	2	-	-	
38	035821	Fence	挡油棉	1	1	1	1	1	

03. MISCELLANEOUS COVER PARTS 罩壳部件

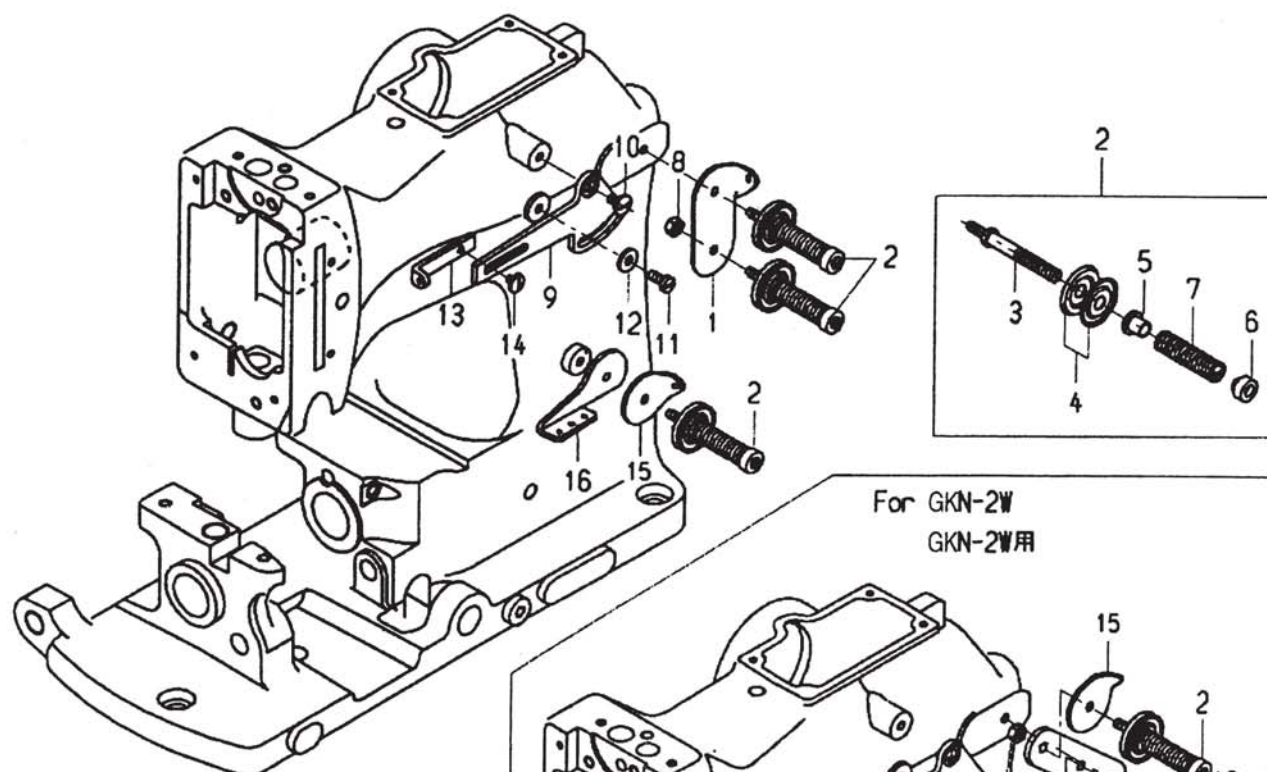


03. MISCELLANEOUS COVER PARTS

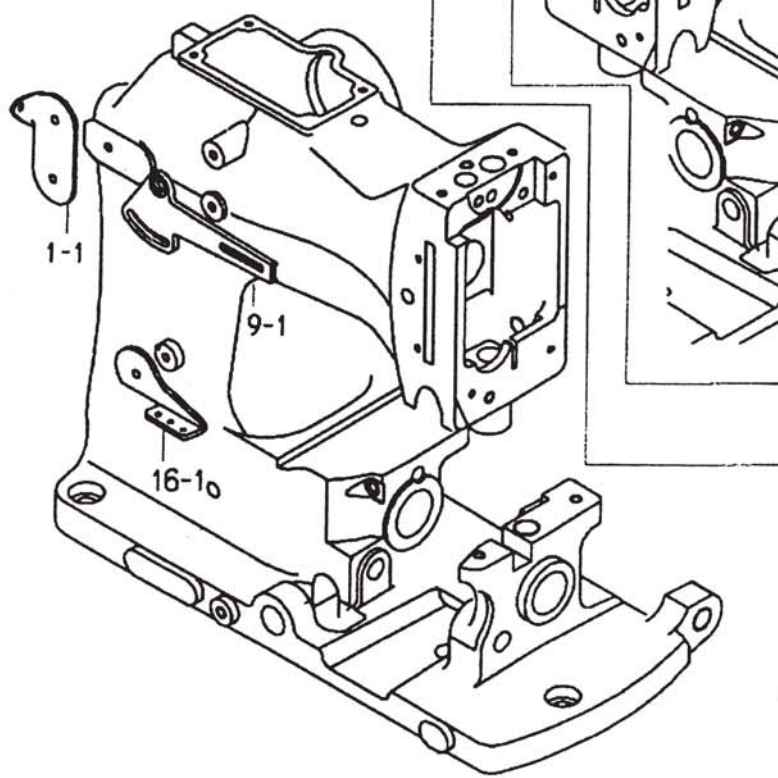
罩壳部件

参考编号 Ref. No.	零部件号码 Part No.	零件名称 Description	数量 Q'ty					备注 Remarks
			-2HS	-2LHS	-2W	-2U	-2LU	
1	035111A	Cloth Plate Ass'y	1	-	1	-	-	(2~6)
1-1	045051A	Cloth Plate Ass'y	-	1	-	-	-	(2~6)
2	035141	Pin	1	1	1	-	-	
3	15/64S28516	Screw for 035141	2	2	2	-	-	
4	035131	Cloth Plate Extension Hinge Stud Bearing	1	1	1	-	-	
5	9/64S40003	Screw for 035131	1	1	1	-	-	
6	11/64S40008	Screw for 035131	1	1	1	-	-	
7	7/32S32007	Screw for 035111A,045051A	3	3	3	3	3	
8	015081	Cloth Plate Slide	1	1	1	1	1	
9	015091	Spring	1	1	1	1	1	
10	3/32S56008	Screw for 015091	2	2	2	2	2	
11	035151	Stopper Spring	1	1	1	1	1	
12	15/64S28018	Screw	1	1	1	1	1	
13	15/64S28017	Screw	1	1	1	1	1	
14	3/16S32028	Screw	1	1	1	1	1	
15	015111	Guide	1	-	1	1	-	
15-1	025031	Guide	-	1	-	-	1	
16	3/16S32004	Screw for 015111	2	2	2	2	2	
17	035232	Gasket	1	1	1	1	1	
18	035222	Rear Cover	1	1	1	1	1	
19	11/64S40006	Screw for 035222	1	1	1	1	1	
20	035491	Gasket	1	1	1	1	1	
21	035481	Top Cover	1	-	1	1	-	
21-1	035481L	Top Cover	-	1	-	-	1	
22	9/64S40005	Screw for 035481	4	4	4	4	4	
23	065401	Rubber Bushing	7	7	7	7	7	
24	035211	Gasket	1	1	1	1	1	
25	035191	Side Cover	1	1	1	1	1	
26	035201	Side Cover Retainer	1	1	1	1	1	
27	9/64S40035	Screw for 035201	6	6	6	6	6	
28	035941	Needle Bar Cover	1	1	1	1	1	
29	11/64S40005	Screw for 035342,035941	2	2	2	2	2	
30	035911	Cover	1	-	1	1	-	
30-1	045191	Cover	-	1	-	-	1	
31	9/64S40004	Screw for 035911,045191	2	2	2	2	2	
32	035181	Gasket	1	1	1	1	1	
33	035171	Face Plate	1	-	1	1	-	
34	9/64S40005	Screw for 035171,035952,045122	3	3	3	3	3	
35	035241	Side Cover	1	-	1	1	-	
35-1	035241L	Side Cover	-	1	-	-	1	
36	5/16W05201	Washer for 035241	1	1	1	1	1	
37	15/64S28017	Screw for 035241	1	1	1	1	1	
38	035261	Oil Filter Cover	1	-	1	1	-	
38-1	045081	Oil Filter Cover	-	1	-	-	1	
39	3/16S32024	Screw for 035261,045081	2	2	2	2	2	
40	9/64S40502	Screw for 035261,045081	1	1	1	1	1	
41	035952	Face Plate	(1)	-	-	(1)	-	
41-1	045122	Face Plate	-	1	-	-	1	
42	035691	Holder	(1)	1	-	(1)	1	(43)
43	15/64S28511	Screw for 035691	(1)	1	-	(1)	1	
44	9/64S40005	Screw for 035691	(2)	2	-	(2)	2	
45	035642A	Needle Cooler Ass'y	(1)	1	-	(1)	1	for DSM,7N,6N
46	035831	Base Holder	(1)	1	-	(1)	1	
47	E01001	U-Bolt (W1/4)	(2)	2	-	(2)	2	
48	1NW1/4	Nut	(4)	4	-	(4)	4	
49	035642	Nozzle	1	1	-	1	1	

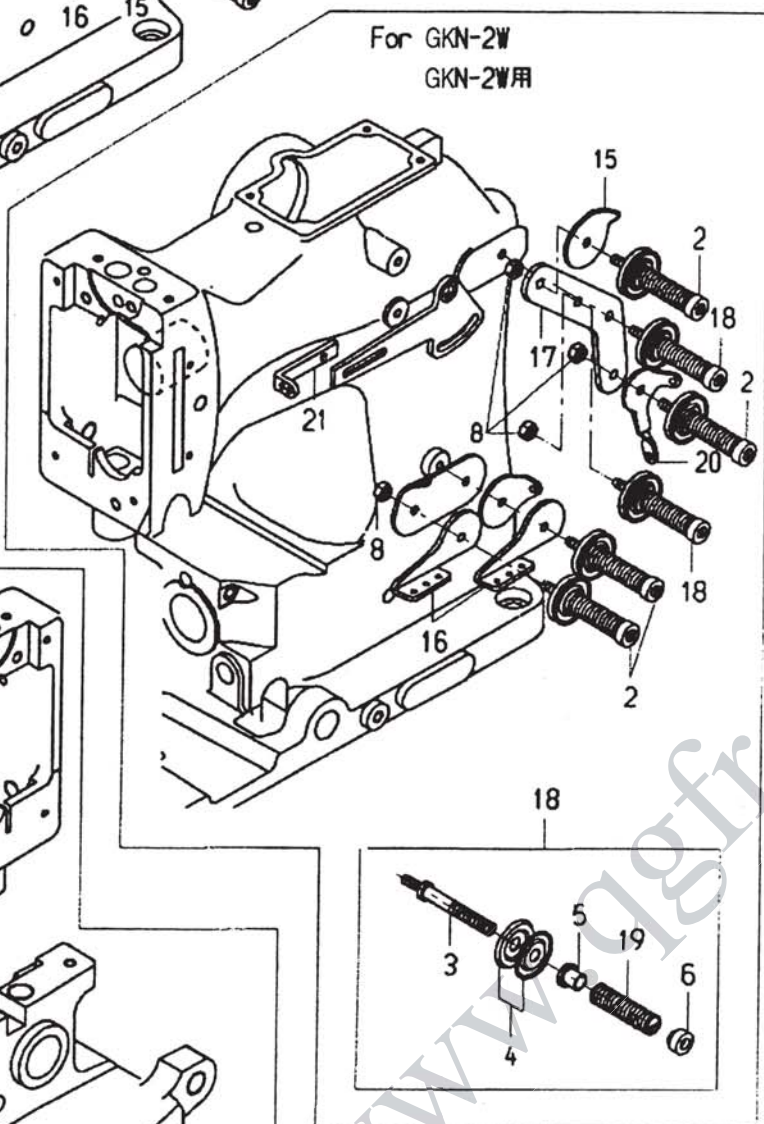
04.THREAD TENSION PARTS 缝线张紧部件



For GKN-2LHS
GKN-2LHS用



For GKN-2W
GKN-2W用

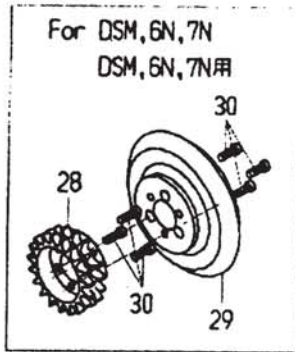


04. THREAD TENSION PARTS

缝线张紧部件

参考编号 Ref. No.	零部件号码 Part No.	零件名称 Description		数量 Q'ty					备注 Remarks
				-2HS	-2LHS	-2W	-2U	-2LU	
1	035011	Tension Thread Guide	张紧导线	1	-	1	1	-	(3-7)
1-1	045011	Tension Thread Guide	张紧导线	-	1	-	-	1	
2	035021A	Thread Tension Ass'y	线张紧总成	3	3	4	3	3	
3	035021	Tension Post	张紧杆	3	3	6	3	3	
4	065261	Tension Disc	张紧盘	6	6	12	6	6	
5	035071	Tension Post Ferrule	张紧杆箍	3	3	6	3	3	
6	065171	Tension Nut	张紧螺母	3	3	4	3	3	
7	035061	Tension Spring	张紧弹簧	3	3	6	3	3	
8	11/64N40104	Nut for 035021A,035021B	螺母, 用035021A,035021B	1	1	4	1	1	
9	035031	Needle Thread Controller A	针线控制器 A	1	-	1	1	-	(3-6.19)
9-1	045021	Needle Thread Controller A	针线控制器 A	-	1	-	-	1	
10	11/64S40014	Screw for 035031,045021	螺钉, 用于035031,045021	1	1	1	1	1	
11	11/64S40009	Screw for 035031,045021	螺钉, 用于035031,045021	1	1	1	1	1	
12	11/64W15103	Washer for 035031,045021	垫圈, 用于035031,045021	1	1	1	1	1	
13	035042	Needle Thread Controller B	针线控制器 B	1	1	-	1	1	
14	9/64S40011	Screw for 035042,035043	螺钉, 用于035042,035043	1	1	1	1	1	
15	015011	Tension Thread Guide	张紧导线	1	1	2	1	1	
16	035083	Looper Thread Controller	钩针线控制器	1	-	2	1	-	
16-1	045032	Looper Thread Controller	钩针线控制器	-	1	-	-	1	
17	035881	Needle Thread Tension Base	针线控制器基座	-	-	1	-	-	
18	035021B	Thread Tension Ass'y	线张紧总成	-	-	2	-	-	
19	035062	Tension Spring	张紧弹簧	-	-	2	-	-	
20	035402	Looper Thread Guide	钩针线导	-	-	1	-	-	
21	035043	Needle Thread Controller B	针线控制器 B	-	-	1	-	-	

曲轴和摇臂轴部件



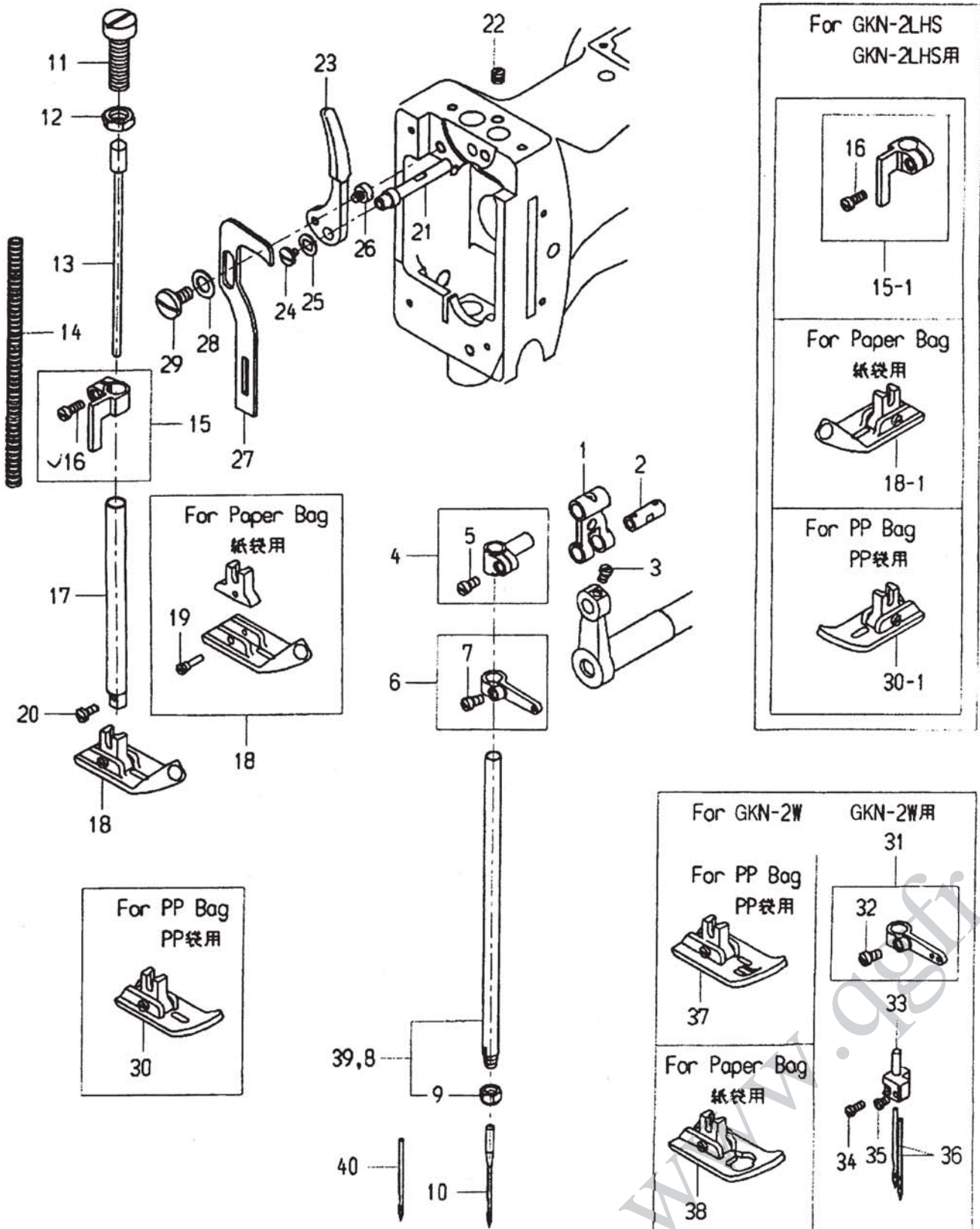
05. CRANK SHAFT AND ARM ROCKER SHAFT

曲轴和摇臂轴部件

参考编号 Ref. No.	零部件号码 Part No.	零件名称 Description	数量 Q'ty					备注 Remarks
			-2HS	-2LHS	-2W	-2U	-2LU	
1	031025	Crank Shaft	曲轴	1	-	1	1	-
1-1	041024	Crank Shaft	曲轴	-	1	-	-	1
2	031201	Bearing Holder Collar B	轴承托架旋塞B	1	1	1	1	1
3	31L1015	"O" Ring	O形环	1	1	1	1	1
4	031141	Stopper Collar	止动器旋塞	1	1	1	1	1
5	031151	Pulley Holder	皮带轮托架	1	1	1	1	1
6	2K3×16	Key for 031151 (3×16)	键 (3X16)	1	1	1	1	1
7	11/64S40504	Screw	螺丝	6	6	6	6	6
8	031181	Pulley	皮带轮	1	(1)	1	1	(1)
9	3/16S28005	Screw for 031181	螺钉, 用于031181	3	3	3	3	3
10	15/64W30102	Washer for 031181	垫圈, 用于031181	1	1	1	1	1
11	15/64S28021	Screw for 031181	螺钉, 用于031181	1	1	1	1	1
12	031131	Balance Weight	平衡块重量	1	1	1	1	1
13	3/16S28018	Screw for 031131	螺钉, 用于031131	2	2	2	2	2
14	032012A	Crank Shaft Connecting Rod Ass'y	曲轴连杆总成	1	-	1	1	- (15-21)
14-1	032012B	Crank Shaft Connecting Rod Ass'y	曲轴连杆总成	-	1	-	-	1 (15-21)
15	11/64S40090	Screw	螺钉	2	2	2	2	2
16	032022	Crank Shaft Connection	曲轴连接装置	1	1	1	1	1
17	4B4×20	Screw	螺钉	4	4	4	4	4
18	1/4S40010	Screw	螺钉	1	1	1	1	1
19	1/4N40207	Nut	螺母	1	1	1	1	1
20	9/32S28015	Spot Screw for 032012A, 032012B	螺钉	1	1	1	1	1
21	9/32S28001	Screw for 032012A, 032021B	螺钉	1	1	1	1	1
22	032041	Oil Scraper	刮油器	1	1	1	1	1
23	11/64S40048	Screw for 032041	螺钉	1	1	1	1	1
24	11/64N40102	Nut for 032041	螺母	1	1	1	1	1
25	032092	Arm Rocker Shaft	摇臂轴	1	-	1	1	-
25-1	042042	Arm Rocker Shaft	摇臂轴	-	1	-	-	1
26	032101	Arm Rocker Shaft Collar	摇臂轴环	1	1	1	1	1 (27)
27	15/64S28512	Screw for 032101	螺钉	2	2	2	2	2
28	031161	Sprocket	链轮齿	(1)	(1)	-	(1)	(1)
29	031171	Pulley	皮带轮	(1)	(1)	-	(1)	(1)
30	3/16S28005	Screw for 031161,031171	螺钉	(6)	(6)	-	(6)	(6)
31	031191	Timing Pulley	定时皮带轮	(1)	(1)	-	(1)	(1)

for DSM,7N,6N

06. NEEDLE BAR AND PRESSER FOOT PARTS 针杆与压脚部件

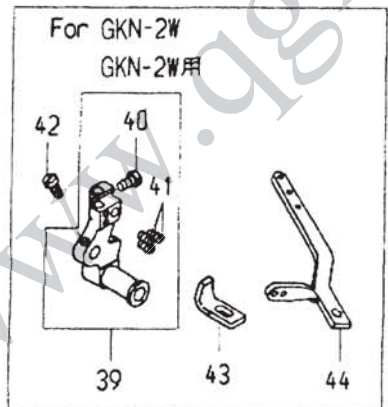
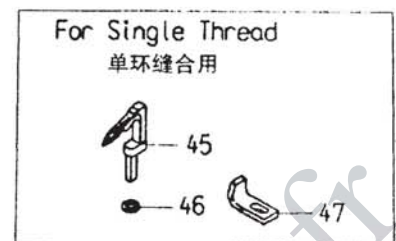
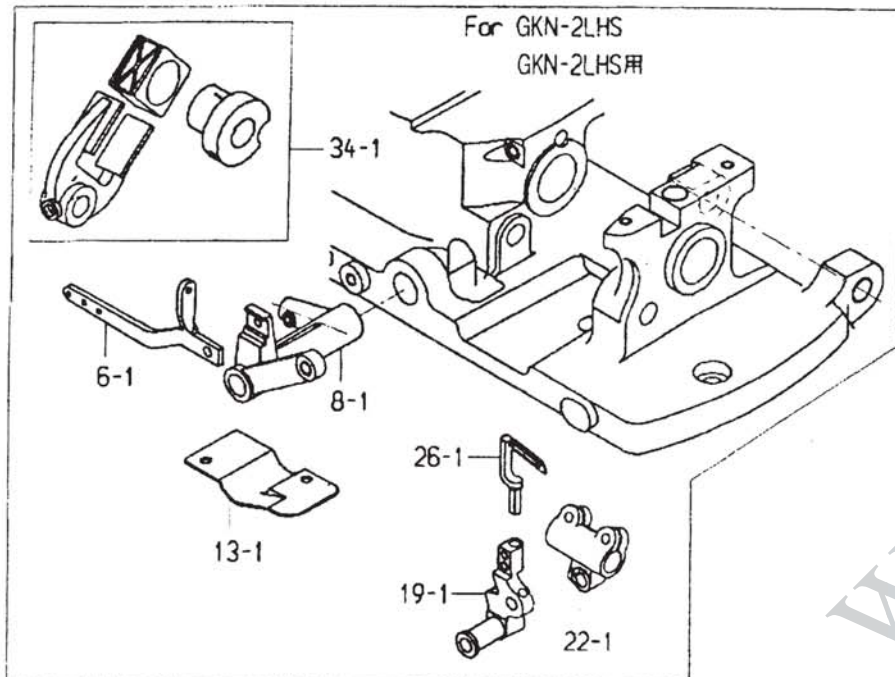
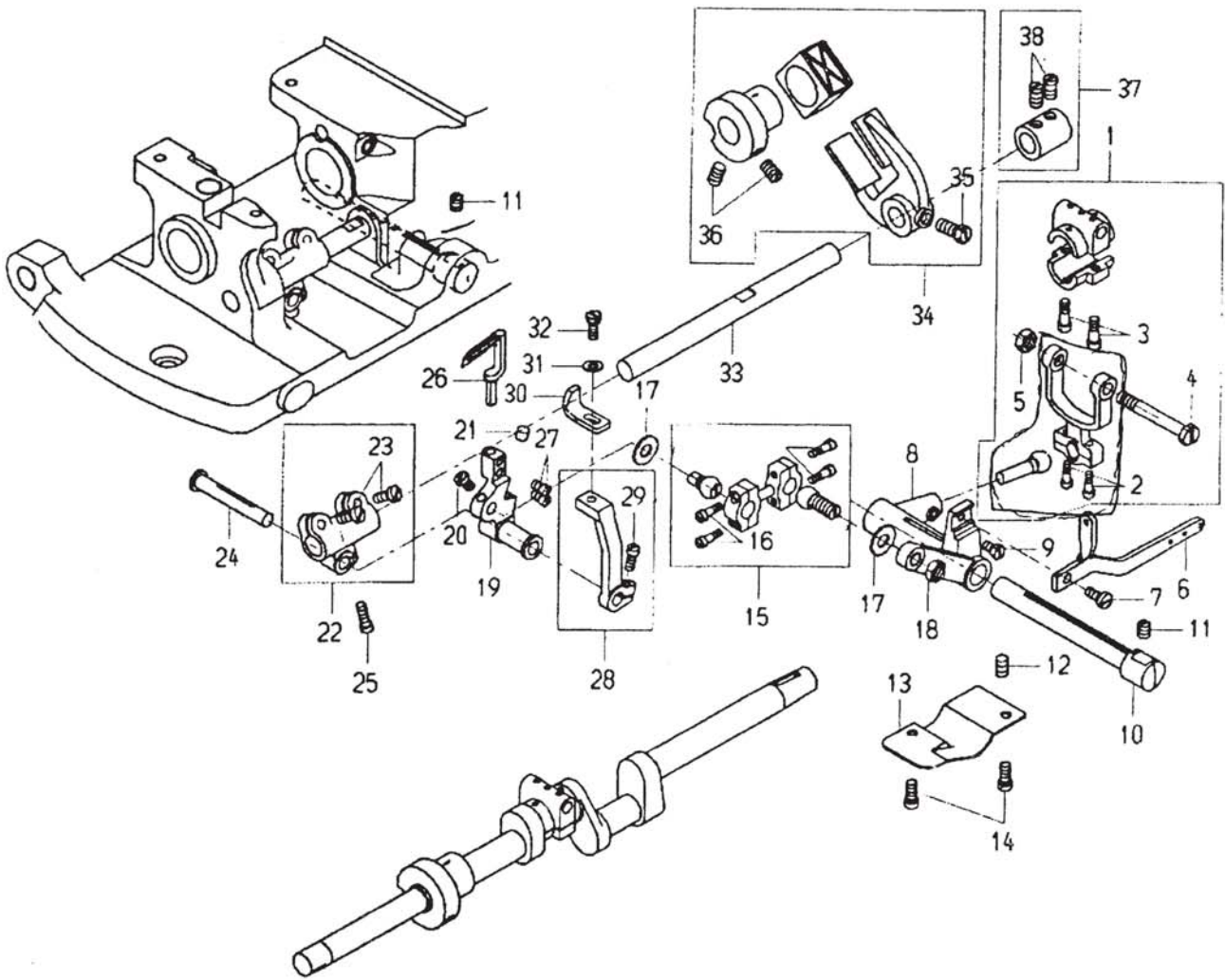


06. NEEDLE BAR AND PRESSER FOOT PARTS

针杆与压脚部件

参考编号 Ref. No.	零部件号码 Part No.	零件名称 Description	数量 Q'ty					备注 Remarks
			-2HS	-2LHS	-2W	-2U	-2LU	
1	032132	Needle Bar Link	1	1	1	1	1	
2	032141	Needle Bar Link Pin	1	1	1	1	1	
3	11/64S40076	Screw for 032141	1	1	1	1	1	
4	032171	Needle Bar Connection	1	1	1	1	1	(5)
5	11/64S40002	Screw for 032171	1	1	1	1	1	
6	032272	Needle Thread Take-Up	1	1	1	1	1	(7)
7	11/64S40002	Screw for 032272	1	1	1	1	1	
8	032112A	Needle Bar Ass'y	1	1	1	1	1	(9)
9	062151	Needle Clamp Nut	1	1	1	1	1	
10	B02001	Needle (DR×2 #25)	1	1	-	1	1	
11	032231	Presser Spring Regulator	1	1	1	1	1	
12	3/8N28214	Nut	1	1	1	1	1	
13	032241	Presser Spring Guide	1	1	1	1	1	
14	032221	Presser Spring	1	1	1	1	1	
15	032191	Presser Bar Connection	1	-	1	1	-	(16)
15-1	042061	Presser Bar Connection	-	1	-	-	1	(16)
16	11/64S40003	Screw for 032191,042061	1	1	1	1	1	
17	032181	Presser Bar	1	1	1	-	-	
18	012201A	Presser Foot Ass'y	1	-	-	-	-	(19)
18-1	022081A	Presser Foot Ass'y	-	1	-	-	-	(19)
19	11/64S40016	Screw	1	1	1	-	-	
20	9/64S40005	Screw for Presser Foot	1	1	1	-	-	
21	012181	Presser Foot Lifter Hinge Pin	1	1	1	1	1	
22	15/64S28512	Screw for 012181	1	1	1	1	1	
23	012171	Presser Foot Lifter Lever	1	1	1	1	1	
24	9/64S40011	Screw for 012171	1	1	1	1	1	
25	7/32W05201	Washer for 012171	1	1	1	1	1	
26	11/64S40029	Screw for 012171	1	1	1	1	1	
27	032261	Presser Foot Lifting Link	1	1	1	1	1	
28	5/16W05201	Washer for 032261	1	1	1	1	1	
29	15/64S28017	Screw for 032261	1	1	1	1	1	
30	012211A	Presser Foot Ass'y	(1)	-	-	-	-	(19)
30-1	022091A	Presser Foot Ass'y (PP Bag)	-	(1)	-	-	-	
31	032351	Needle Thread Take-Up	-	-	1	-	-	(32)
32	11/64S40002	Screw for 032351	-	-	1	-	-	
33	032362	Needle Holder	-	-	1	-	-	
34	9/64S40002	Screw for Needle	-	-	1	-	-	
35	9/64S40001	Screw for Needle	-	-	1	-	-	
36	B11001	Needle (UY143GS 200)	-	-	2	-	-	
	B11002	Needle (UY143GS 230)	-	-	(2)	-	-	
37	032342A	Presser Foot Ass'y	-	-	1	-	-	(19)
38	032343A	Presser Foot Ass'y (Paper Bag)	-	-	(1)	-	-	(19)
39	032111A	Needle Bar Ass'y	(1)	-	-	(1)	-	(9)
40	B01002	Needle (DN×1 #25)	(1)	-	-	(1)	-	

07. LOOPER ROCKER AND CONNECTING PARTS 弯针轴与连接部件

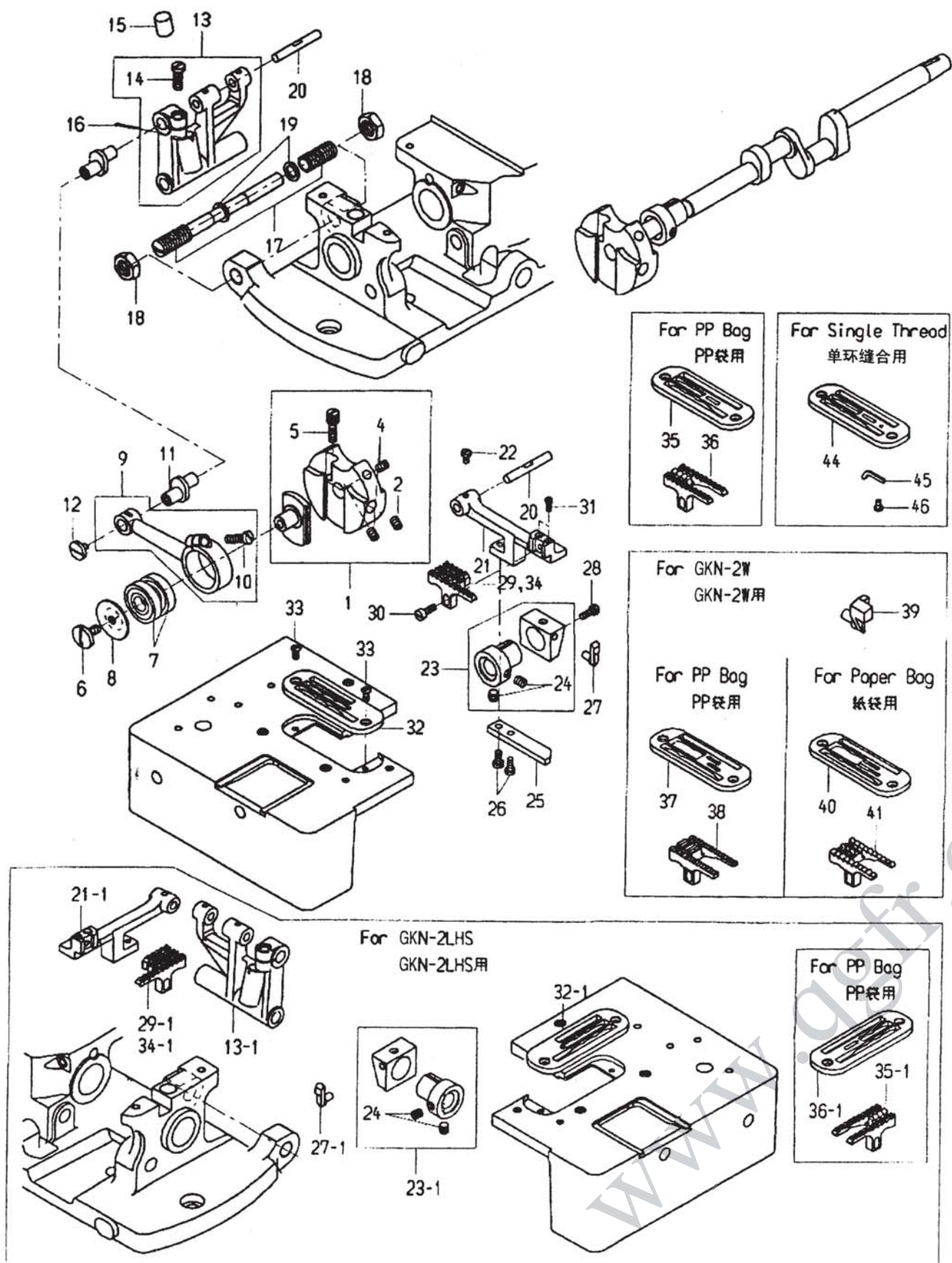


07. LOOPER ROCKER AND CONNECTING PARTS

弯针轴与连接部件

参考编号 Ref. No.	零部件号码 Part No.	零件名称 Description	数量 Q'ty					备注 Remarks
			2HS	2LHS	2W	2U	2LU	
1	033022A	Looper Bell Crank Connection Rod Ass'y	1	1	1	1	1	(2-5)
2	9/64S40061	Screw	2	2	2	2	2	
3	11/64S40090	Screw	2	2	2	2	2	
4	1/4S40010	Screw	1	1	1	1	1	
5	1/4N40207	Nut	1	1	1	1	1	
6	033072	Looper Thread Take-up	1	-	-	1	-	
6-1	043081	Looper Thread Take-up	-	1	-	-	1	
7	11/64S40009	Screw for 033072, 043081	1	1	1	1	1	
8	033041	Looper Bell Crank	1	-	1	1	-	
8-1	043021	Looper Bell Crank	-	1	-	-	1	
9	11/64S40091	Screw for 033022A	1	1	1	1	1	
10	033051	Looper Bell Crank Hinge Pin	1	1	1	1	1	
11	15/64S28513	Screw for 033051	1	1	1	1	1	
12	15/64S28515	Screw for 033051	1	1	1	1	1	
13	033061	Looper Bell Crank Inside Cover	1	-	1	1	-	
13-1	043031	Looper Bell Crank Inside Cover	-	1	-	-	1	
14	3/16S28009	Screw for 033061, 043031	2	2	2	2	2	
15	033092A	Looper Connecting Rod Ass'y	1	1	1	1	1	(16)
16	9/64S40061	Screw	4	4	4	4	4	
17	9/32W10106	Washer	2	2	2	2	2	
18	9/32N28210	Nut for 033092A	1	1	1	1	1	
19	033141	Looper Carrier	1	-	-	1	-	
19-1	043061	Looper Carrier	-	1	-	-	1	
20	11/64S40005	Screw for 033092A	1	1	1	1	1	
21	245411	Felt	1	1	1	1	1	
22	033131	Looper Rocker Shaft Crank	1	-	1	1	-	(23)
22-1	043051	Looper Rocker Shaft Crank	-	1	-	-	1	(23)
23	11/64S40009	Screw for 033131, 043051	2	2	2	2	2	
24	033151	Looper carrier Hinge Pin	1	1	1	1	1	
25	11/64S40004	Screw for 033151	1	1	1	1	1	
26	033121	Looper	1	-	2	1	-	
26-1	043011	Looper	-	1	-	-	1	
27	11/64S40001	Screw for 033121, 043011	2	2	-	2	2	
28	033161	Loop Retainer Base	1	1	1	1	1	(29)
29	11/64S40003	Screw for 033161	1	1	1	1	1	
30	033171	Loop Retainer	1	1	-	1	1	
31	11/64W10101	Washer for 033171	1	1	1	1	1	
32	11/64S40049	Screw for 033171	1	1	1	1	1	
33	033183	Looper Rocker Shaft	1	1	1	1	1	
34	033201A	Looper Driving Eccentric Cam Ass'y	1	-	1	1	-	(35,36)
34-1	043071A	Looper Driving Eccentric Cam Ass'y	-	1	-	-	1	(35,36)
35	1/4S40006	Screw	1	1	1	1	1	
36	1/4S40504	Screw	2	2	2	-	-	
37	033192	Looper Rocker Shaft Collar	1	1	1	1	1	(38)
38	15/64S28007	Screw for 033192	2	2	2	2	2	
39	033312	Looper Carrier	-	-	1	-	-	(40,41)
40	9/64S40064	Screw	-	-	1	-	-	
41	9/64S40066	Screw	-	-	3	-	-	
42	11/64S40006	Screw for 033092A	-	-	1	-	-	
43	033291	Looper Retainer	-	-	1	-	-	
44	033301	Looper Thread Take-Up	-	-	1	-	-	
45	303191	Looper for Single Thread	(1)	-	-	(1)	-	
46	11/64W12102	Washer	(1)	-	-	(1)	-	
47	033172	Looper Retainer	(1)	-	-	(1)	-	

08. FEED MECHANISM DRIVING PARTS 送料驱动部件

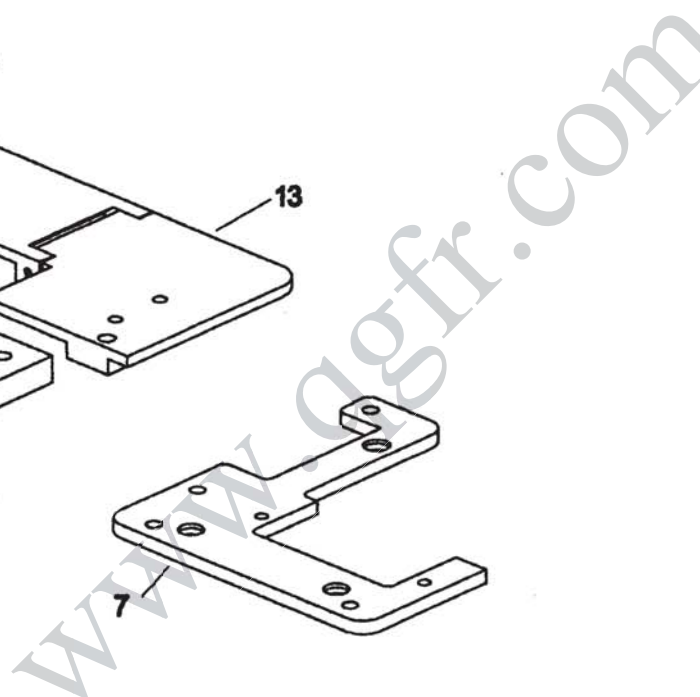


08. FEED MECHANISM DRIVING PARTS

送料驱动部件

参考编号 Ref. No.	零部件号码 Part No.	零件名称 Description	数量 Q'ty					备注 Remarks
			-2HS	-2LHS	-2W	-2U	-2LU	
1	034014A	Feed Driving Eccentric Cam Ass'y	1	1	1	1	1	(2-5)
2	1/4S40508	Screw	1	1	1	1	1	
4	15/64S28526	Screw	2	2	2	2	2	(10)
5	7/32S32004	Screw	1	1	1	1	1	
6	15/64S28012	Screw for 031181	1	1	1	1	1	
7	1A01013	Ball Bearing (EN12)	2	2	2	2	2	
8	034111	Bearing Presser Collar	1	1	1	1	1	
9	034032	Feed Connecting Rod	1	1	1	1	1	
10	15/64S28002	Screw for 034032	1	1	1	1	1	
11	034041	Feed Rocker Crank Pin	1	1	1	1	1	
12	11/64S40032	Screw for 034041	1	1	1	1	1	
13	034052	Feed Rocker	1	-	1	1	-	(12)
13-1	044012	Feed Rocker	-	1	-	-	1	(12)
14	15/64S28002	Screw for 034041	1	1	1	1	1	(24)
15	035721	Oil Felt	1	1	1	1	1	
16	3P1.5×20	Split Pin	1	1	1	1	1	
17	014011A	Feed Rocker Screw Shaft Ass'y	1	1	1	1	1	
18	1/2N20216	Nut	2	2	2	2	2	
19	3/8W15108	Washer	2	2	2	2	2	
20	034101	Feed Bar Shaft	1	1	1	-	-	
21	034061	Feed Bar	1	-	1	1	-	
21-1	044041	Feed Bar	-	1	-	-	1	
22	11/64S40005	Screw for 034061,044041	1	1	1	1	1	
23	034091A	Feed Lift Eccentric Ass'y	1	-	1	1	-	(24)
23-1	044031A	Feed Lift Eccentric Ass'y	-	1	-	-	1	(24)
24	1/4S40503	Screw for 034091A,044031A	2	2	2	2	2	Special Order 特注
25	034071	Feed Bar Shoe	1	1	1	1	1	
26	11/64S40009	Screw for 034071	2	2	2	2	2	
27	034122	Needle Guide	1	-	-	1	-	
27-1	044052	Needle Guide	-	1	-	-	1	
28	11/64S40075	Screw for 034122,044052,034212	1	1	1	1	1	
29	014311	Feed Dog	1	-	-	-	-	
29-1	024121	Feed Dog	-	1	-	-	-	
30	11/64S40048	Screw for 014311,024121,034202	1	1	1	1	1	
31	9/64S40002	Screw for 014311,024121,034202	1	1	1	1	1	
32	014241	Throat Plate	1	-	-	-	-	(1)
32-1	024091	Throat Plate	-	1	-	-	-	
33	11/64S40007	Screw for 014241,024091,034192	2	2	2	2	2	
34	014351	Feed Dog (Stelight)	(1)	-	-	-	-	
34-1	024161	Feed Dog (Stelight)	-	(1)	-	-	-	
35	014221	Throat Plate, for PP Bag	(1)	-	-	-	-	
35-1	024101	Feed Dog, for PP Bag	-	(1)	-	-	-	
36	014291	Feed Dog, for PP Bag	(1)	-	-	-	-	
36-1	024071	Throat Plate, for PP Bag	-	(1)	-	-	-	
37	034192	Throat Plate	-	-	1	-	-	(1)
38	034202	Feed Dog	-	-	1	-	-	
39	034212	Needle Guide	-	-	1	-	-	
40	034193	Throat Plate, for Paper Bag	-	-	(1)	-	-	
41	034203	Feed Dog, for Paper Bag	-	-	(1)	-	-	
44	014261	Throat Plate	(1)	-	-	-	-	
45	014271	Throat Plate Thread Retainer	(1)	-	-	(1)	-	
46	3/32S56004	Screw	(1)	-	-	(1)	-	

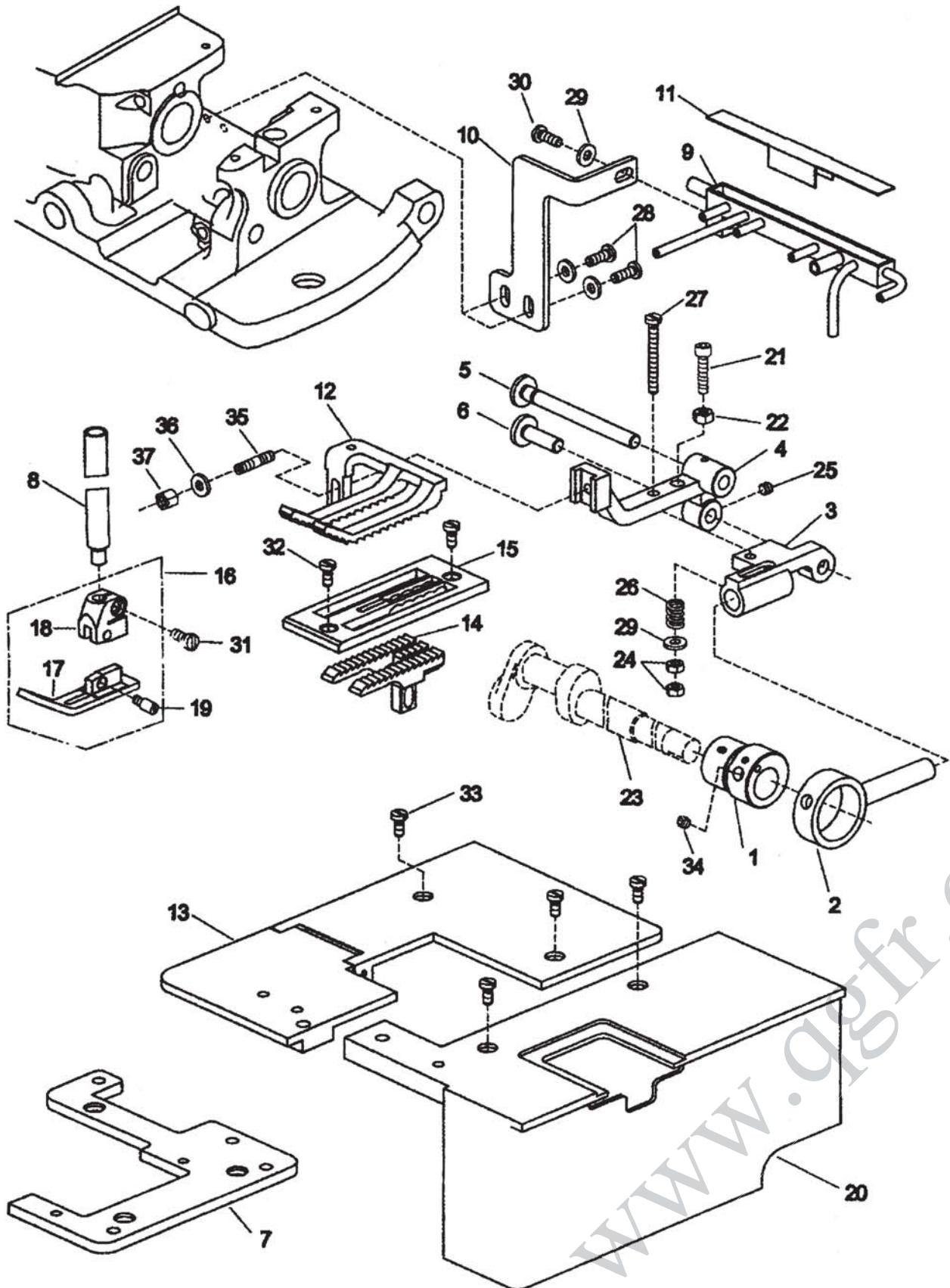
上送料機牙零部 (GKN-2U)



09.THE UPPER FEEDING MACHINE TOOTH PARTS (GKN-2U)
上送料机牙零部件 (GKN-2U)

参考编号 Ref. No.	零部件号码 Part No.	零件名称 Description	数量 Q'ty					备注 Remarks
			-2HS	-2LHS	-2W	-2U	-2LU	
1	DN201	Double-headed eccentric				1		
2	DN202	Upper feed dog Connecting Rod A				1		
3	DN203	Upper feed dog Connecting Rod B				1		
4	DN204	Upper feed dog holder				1		
5	DN205	Upper feed dog holder shaft A				1		
6	DN206	Upper feed dog holder shaft B				1		
7	DN207	Needle plate holder				1		
8	DN208	Pressure bar				1		
9	DN209	Oil box				1		
10	DN210	Oil box holder				1		
11	DN211	Oil box cover				1		
12	314141U	Upper feed dog				1		
13	315381U	Shell B				1		
14	314241U	Feed Dog				1		
15	314151U	Throat plate				1		
16	312091UA	Presser foot ass'y				1		17-19
17	312091U	Presser foot				1		
18	312091-2	Presser foot handle				1		
19	11/64S40064	Screws ,used for 312091U				1		
20	315371	Shell A				1		
21	NL516	Screws ,used for DN203				1		
22	701	Nut				1		
23	031025	Main shaft				1		
24	710	Nut				2		
25	11/64S40504	Screws ,used for DN204				1		
26	106171	Spring				1		
27	YT4×35	Screws ,used for DN203				1		
28	YT5×12H	Screws ,used for DN210				2		
29	802	Gasket				4		
30	YT5×15H	Screws ,used for DN209				1		
31	11/64S40006	Screws ,used for 312091-2				1		
32	11/64S40007	Screws ,used for 314151U				2		
33	78057	Screws ,used for 315371				4		
34	PD605	Screws ,used for DN201				2		
35	11/64S40505	Screws ,used for DN204				1		
36	3W5	Gasket				1		
37	11/64N40204	Nut				1		

10.THE UPPER FEEDING MACHINE TOOTH PARTS(GKN-2LU)
 上送料机牙零部件 (GKN-2LU)



10.THE UPPER FEEDING MACHINE TOOTH PARTS (GKN-2LU) 上送料机牙零部件(GKN-2LU)

参考编号 Ref. No.	零部件号码 Part No.	零件名称 Description	数量 Q'ty					备注 Remarks
			-2HS	-2LHS	-2W	-2U	-2LU	
1	DN201L	Double-headed eccentric					1	
2	DN202	Upper feed dog Connecting Rod A					1	
3	DN203L	Upper feed dog Connecting Rod B					1	
4	DN204L	Upper feed dog holder					1	
5	DN205	Upper feed dog holder shaft A					1	
6	DN206	Upper feed dog holder shaft B					1	
7	DN207L	Needle plate holder					1	
8	DN208	Pressure bar					1	
9	DN209L	Oil box					1	
10	DN210L	Oil box holder					1	
11	DN211	Oil box cover					1	
12	314141LU	Upper feed dog					1	
13	315381LU	Shell B					1	
14	314241LU	Feed Dog					1	
15	314151LU	Throat plate					1	
16	312091LUA	Presser foot ass'y					1	17-19
17	312091U	Presser foot					1	
18	312091-2L	Presser foot handle					1	
19	11/64S40064	Screws ,used for 312091U					1	
20	315371L	Shell A					1	
21	NL516	Screws ,used for DN203L					1	
22	701	Nut					1	
23	041024	Main shaft					1	
24	710	Nut					2	
25	11/64S40504	Screws ,used for DN204L					1	
26	106171	Spring					1	
27	YT4×35	Screws ,used for DN203L					1	
28	YT5×12H	Screws ,used for DN210L					2	
29	802	Gasket					4	
30	YT5×15H	Screws ,used for DN209L					1	
31	11/64S40006	Screws ,used for 312091-2L					1	
32	11/64S40007	Screws ,used for 314151LU					2	
33	78057	Screws ,used for 315371L					4	
34	PD605	Screws ,used for DN201L					2	
35	11/64S40505	Screws ,used for DN204L					1	
36	3W5	Gasket					1	
37	11/64N40204	Nut					1	

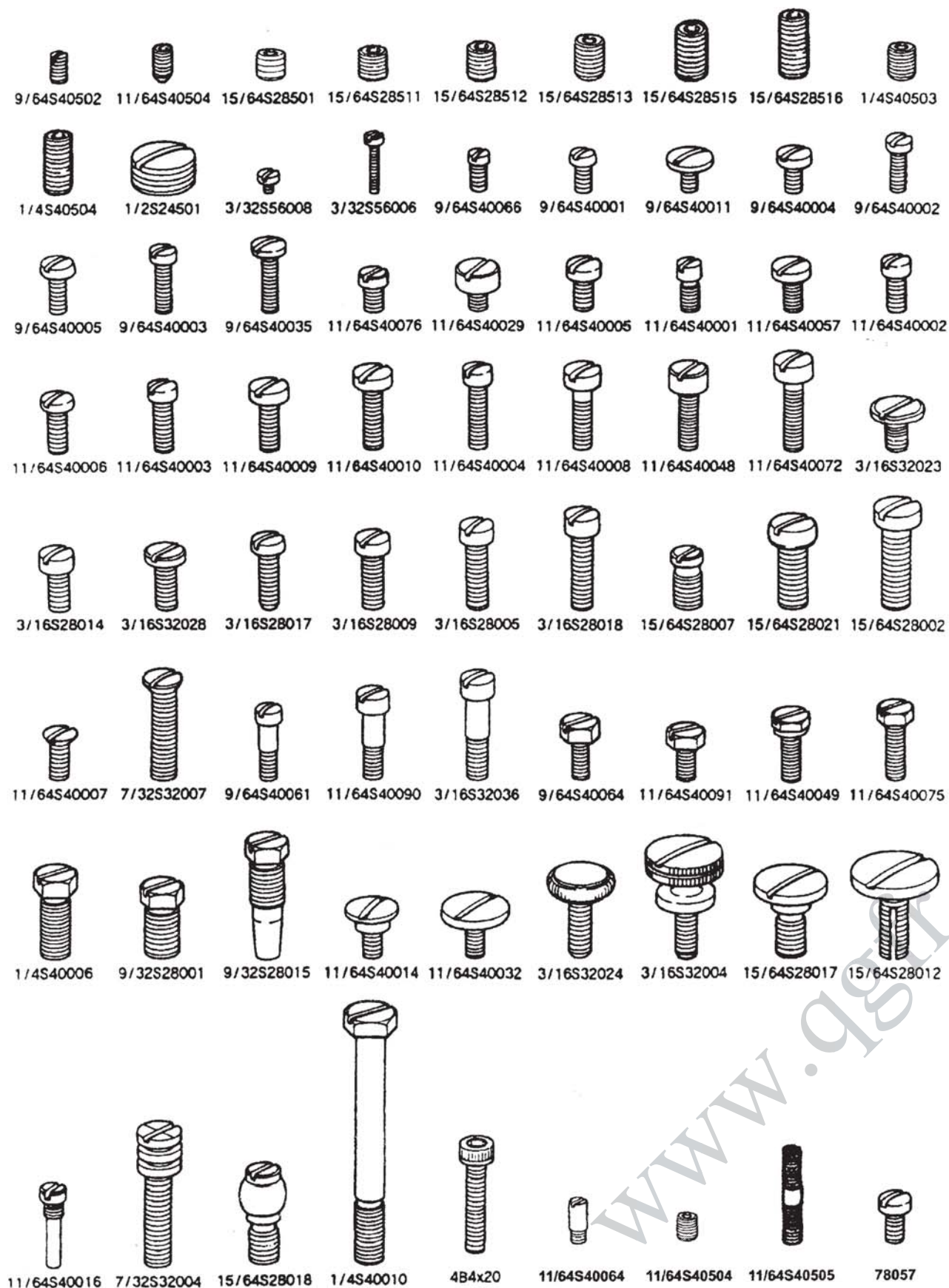
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312091-2L	37-18	9/64S40502	23-40	15/64S28007	31-38	11/64W12102	31-46
314141U	35-12	11/64S40001	31-27	15/64S28012	33-6	11/64W15103	21-34,25-12
314141LU	37-12	11/64S40002	29-5,29-7	15/64S28017	23-13,23-37	7/32W05201	29-25
314151U	35-15		29-32		29-29	15/64W30102	27-10
314151LU	37-15	11/64S40003	29-16,31-29	15/64S28018	23-12	5/16W05201	23-36,29-28
314241U	35-14	11/64S40004	31-25	15/64S28021	27-11	3/8W15108	33-19
314241LU	37-14	11/64S40005	21-37,23-29	15/64S28501	19-18	2W5	35-36,37-36
315371	35-20		31-20,33-22	15/64S28511	23-43	2W10	21-11
315371L	37-20	11/64S40006	23-19,31-42	15/64S28512	27-27,29-22	802	35-29,37-29
315381U	35-13		35-31,37-31	15/64S28513	19-10,31-11		
315381LU	37-13	11/64S40007	33-33,35-32	15/64S28515	31-12	OTHER PARTS	
			37-32			(其它部件)	
DN201	35-1	11/64S40008	23-6	15/64S28516	19-12,19-16	1A01002	19-6
DN201L	37-1	11/64S40009	21-35,25-11		19-22,21-15	1A01004	19-4
DN202	35-2,37-2		31-7,31-23		23-3	1A01013	33-7
DN203	35-3		33-26	15/64S28526	33-4	B01002	29-40
DN203L	37-3	11/64S40010	21-24	1/4S40006	31-35	B02001	29-10
DN204	35-4	11/64S40014	25-10	1/4S40010	27-18,31-4	B11001	29-36
DN204L	37-4	11/64S40016	29-19	1/4S40503	33-24	B11002	29-36
DN205	35-5,37-5	11/64S40029	29-26	1/4S40504	31-36	D04003	19-1
DN206	35-6,37-6	11/64S40032	33-12	9/32S28001	27-21	D05002	21-5
DN207	35-7	11/64S40048	27-23,33-30	9/32S28015	27-20	D06001	21-10
DN207L	37-7	11/64S40049	31-32	1/2S24501	21-17	D07006	21-30
DN208	35-8,37-8	11/64S40057	33-2	W3/8S16001	21-2	D07008	21-31
DN209	35-9	11/64S40064	35-19,37-19	4B4×20	27-17	E01001	23-47
DN209L	37-9	11/64S40072	21-20	78057	35-33,37-33	31L1015	27-3
DN210	35-10	11/64S40075	33-28	NL516	35-21,37-21	2K3×16	27-6
						3P1.5×20	33-16





NL516



PD605



YT4×35



YT5×12H



YT5×15H

NUT&WASHER (螺母和垫圈)



11/64N40102



11/64N40201



11/64N40104



1/4N40207



9/32N28210



3/8N28214



1/2N20216



701



710



11 / 64N40204



11/64W10101



11/64W15103



7/32W05201



15/64W30102



9/32W10106



5/16W05201



3/8W15108



2W10



2W5



802